OK 67.53

Thin coated rutile MMA-electrode especially designed for pipe welding of duplex stainless steel. i.e. UNS S31803, CrNiMoN22-5-3, CrNiN23-4. Ideal for root runs and positional welding.

Classifications:	Werkstoffnummer :1.4462, EN ISO 3581-A:E 22 9 3 N L R 1 2, SFA/AWS A5.4:(E2209-16)
Approvals:	CE EN 13479, VdTÜV 05422

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	DC+, AC
Ferrite Content:	FN 30-45
Alloy Type:	Duplex CrNi
Coating Type:	Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	680 MPa	860 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	20 °C	48 J
As welded	-20 °C	40 J
As welded	-30 °C	37 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.03	0.7	1.0	9.3	23.7	3.4	0.18	40

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 300 mm	30-80 A	23 V	0.63	96	54 s	0.7 kg/h
3.2 x 350 mm	70-110 A	27 V	0.57	51	64 s	1.0 kg/h