

OK 67.50



OK 67.50 is an acid rutile coated type for welding of austenitic-ferritic stainless steels of CrNiMoN 22 5 3 - and CrNiN 23 4-types. The duplex all weld metal offers a high strength level combined with good ductility. The pitting corrosion resistance is good and the all weld metal is not sensitive for stress corrosion cracking.

Classifications	SFA/AWS A5.4 : E2209-17 EN ISO 3581-A : E 22 9 3 N L R 3 2 CSA W48 : E2209-17 Werkstoffnummer : 1.4462
Approvals	ABS E2209-17 ABS Stainless* BV 2209 CE EN 13479 CWB CSA W48: E2209-17 DNV-GL Duplex NAKS/HAKC 3.2 mm NAKS/HAKC 4.0 mm RINA 2209 Sepro UN A 272580 VdTUV 04368

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

Welding Current	DC+, AC
Ferrite Content	FN 35-50
Alloy Type	Duplex CrNiMoN
Coating Type	Acid Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	691 MPa (100 ksi)	857 MPa (124 ksi)	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C (68 °F)	50 J (37 ft-lb)
As Welded	-30 °C (-22 °F)	41 J (30 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.03	0.8	0.8	8.8	23.2	3.2	0.16	42

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Burn-off Time/ Electrode	Deposition Efficiency %	Deposition Rate @ 90% I max
2.0 x 300.0 mm (5/64 x 11.8 in.)	30-65 A	29 V	152	33 sec	55 %	0.7 kg/h (1.5 lb/h)
2.5 x 300.0 mm (0.098 x 11.8 in.)	50-90 A	27 V	91	38 sec	58 %	1.0 kg/h (2.2 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	80-120 A	28 V	47	55 sec	58 %	1.4 kg/h (3.1 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	90-160 A	29 V	32	59 sec	58 %	1.9 kg/h (4.2 lb/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	150-220 A	30 V	20	64 sec	58 %	2.8 kg/h (6.2 lb/h)