OK 67.45

Austenitic stainless-steel electrode producing a weld metal with less than 5% ferrite. The tough weld metal has excellent crack resistance, even when welding steels with very poor weldability. Suitable for joining 12-14% manganese steel to itself or other steels. Also suitable for buffer layers before hardfacing.

Classifications	SFA/AWS A5.4 : (E307-15) EN ISO 3581-A : E 18 8 Mn B 2 2
Approvals	ABS Stainless CE EN 13479 Seproz UNA 272580 VdTÜV 01580

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

Welding Current	DC+
Ferrite Content	FN <5
Alloy Type	Stainless austenitic CrNiMn
Coating Type	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	470 MPa (68 ksi)	605 MPa (88 ksi)	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C (68 °F)	85 J (63 ft-lb)
As Welded	-60 °C (-76 °F)	50 J (37 ft-lb)

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Burn-off Time/ Electrode	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 300.0 mm (0.098 x 11.8 in.)	50-80 A	23 V	102	50 sec	58 %	0.7 kg/h (1.5 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	70-100 A	24 V	51	71 sec	60 %	1.1 kg/h (2.4 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	80-140 A	24 V	33	73 sec	60 %	1.5 kg/h (3.3 lb/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	150-200 A	25 V	22	80 sec	60 %	2.2 kg/h (4.9 lb/h)

410041-en_US-FactSheet_Main-01 2022-01-17