

OK 67.43



Austenitic stainless steel MMA-electrode giving a weld metal of the CrNiMn-type. The weld metal, which contains a small amount of uniformly distributed ferrite, is tough and has an excellent crack resistance. Suitable for joining 13%Mn-steels and such steels to other steels. Also suitable for welding of other steels with very poor weldability.

Classifications	SFA/AWS A5.4 : (E307-16) EN 14700 : E Fe10 EN ISO 3581-A : E 18 8 Mn R 1 2 Werkstoffnummer : 1.4370
Approvals	CE EN 13479 DB 30.039.07 VdTUV 06797

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

Welding Current	AC, DC+
Ferrite Content	FN <5
Alloy Type	Austenitic, CrNiMn
Coating Type	Rutile Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	440 MPa (64 ksi)	630 MPa (91 ksi)	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C (68 °F)	80 J (59 ft-lb)
As Welded	-60 °C (-76 °F)	52 J (38 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	N	Ferrite FN
0.08	5.4	0.8	9.1	18.4	0.08	2

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.)	60-80 A	22 V	106	46 sec	51 %	0.8 kg/h (1.8 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	90-115 A	23 V	57	54 sec	54 %	1.3 kg/h (2.9 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	100-150 A	23 V	35	61 sec	56 %	1.7 kg/h (3.7 lb/h)
5.0 x 450.0 mm (0.197 x 17.7 in.)	130-210 A	24 V	17	86 sec	60 %	2.8 kg/h (6.2 lb/h)