

## OK 68.82

High alloy stainless electrode of unusual versatility, giving a ferritic-austenitic duplex weld metal with an approximate ferrite content of FN 40. The weld metal is resistant to stress corrosion attack and highly insensitive to dilution by melted parent metal. Applications: joining of HWT steels, dissimilar steels, welding steels of poor weldability eg spring steels, surfacing rails, rolls forging die hot work tools, die for plastics, etc. Good scaling resistance up to 1150 °C.

Specifications	
<b>Classifications</b>	EN 14700 : E Fe11 EN ISO 3581-A : E 29 9 R 1 2 SFA/AWS A5.4 : (E312-17) Werkstoffnummer : 1.4337
<b>Approvals</b>	CE : EN 13479 UKCA : EN 13479

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

<b>Welding Current</b>	DC+, AC
<b>Ferrite Content</b>	FN 30 - 50
<b>Alloy Type</b>	Stainless duplex
<b>Coating Type</b>	Acid Rutile

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS</b>			
As Welded	500 MPa	750 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
<b>AWS</b>		
As Welded	20 °C	40 J

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.13	0.6	1.1	9.9	29.1	0.2	0.10	40

Deposition Data						
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate	
2.0 x 300.0 mm	40-60 A	26 V	54 %	33 sec	0.7 kg/h	
2.5 x 300.0 mm	50-85 A	25 V	52 %	45 sec	1.0 kg/h	
3.2 x 350.0 mm	55-120 A	26 V	52 %	57 sec	1.3 kg/h	
4.0 x 350.0 mm	75-170 A	30 V	55 %	60 sec	2.0 kg/h	