

# OK 67.45

Type Lime-basic

SMAW  
(E307-15)

## Description

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. It is also suitable for buffer layers before hardfacing.

## Welding current

DC+



## Classifications

EN 1600 E 18 8 Mn B 4 2  
SFA/AWS A5.4 (E307-15)

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
0.11	0.5	6.0	18.5	8.5	<0.5	<0.5

## Typical mech. properties all weld metal

Yield stress, MPa 470  
Tensile strength, MPa 605  
Elongation A5, % 35

## Charpy V

Test temps, °C Impact values, J  
+20 85

Ferrite content FN <5

## Approvals

ABS Stainless  
Sepros UNA 409820  
UDT EN 1600  
VdTÜV 01580

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.5	300	50-80	23	0.58	102	0.7	50
3.2	350	70-100	24	0.60	51	1.1	71
4.0	350	100-140	24	0.60	33	1.5	73
5.0	350	150-200	25	0.60	22	2.2	80

This document was created with Win2PDF available at <http://www.win2pdf.com>.  
The unregistered version of Win2PDF is for evaluation or non-commercial use only.  
This page will not be added after purchasing Win2PDF.