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:	EN 1600:E 18 8 Mn B 4 2, SFA/AWS A5.4:(E307-15)
Approvals:	CE EN 13479 , ABS Stainless , Sepros UNA 272580 , VdTÜV 01580

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

Typical Tensile Properties

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

Typical Charpy V-Notch Properties

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

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	N	Ferrite FN
0.09	6.3	0.3	9.1	18.8	0.06	1

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 300 mm (3/32 x 12 in.)	50-80 A	23 V	0.58	102	50 s	0.7 kg/h (1.5 lb/h)
3.2 x 350 mm (1/8 x 14 in.)	70-100 A	24 V	0.60	51	71 s	1.1 kg/h (2.4 lb/h)
4.0 x 350 mm (5/32 x 14 in.)	80-140 A	24 V	0.60	33	73 s	1.5 kg/h (3.3 lb/h)
5.0 x 350 mm (3/16 x 14 in.)	150-200 A	25 V	0.60	22	80 s	2.2 kg/h (4.8 lb/h)

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