

OK 68.81

OK 68.81 is a high-alloyed electrode which deposits a ferritic-austenitic duplex weld metal with approx. 40% ferrite. It is resistant to stress corrosion and is highly insensitive to dilution. Good scaling resistance up to 1150°C. OK 68.81 is used for joining dissimilar steels, steels with reduced weldability and buffer layers prior to hardfacing. Applications: rolls, forging dies, hot-work tools, dies for plastics and so on.

Classifications:	EN 14700:E Fe11, EN ISO 3581-A:E 29 9 R 3 2, SFA/AWS A5.4:E312-17, Werkstoffnummer :1.4337
Approvals:	CE EN 13479, Seproz UNA 272580

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	610 MPa (88.5 ksi)	790 MPa (114.5 ksi)	22 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	+20 °C (68 °F)	30 J (22 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.13	0.9	0.7	10.2	28.9	0.04	0.09	40

Deposition Data

Diameter	Current	Voltage
2 mm (5/64 in.)	40-60 A	22 V
2.5 mm (3/32 in.)	50-85 A	24 V
3.2 mm (1/8 in.)	60-125 A	25 V
4 mm (5/32 in.)	80-175 A	26 V
5 mm (3/16 in.)	150-240 A	28 V