

OK 68.82



OK 68.82 is a high-alloyed electrode which deposits a ferritic-austenitic duplex weld metal with approx. 30-35% ferrite. It is resistant to stress corrosion and is highly insensitive to dilution. Good scaling resistance up to 1150°C. OK 68.82 is used for joining steels with reduced weldability and buffer layers prior to hard surfacing, dissimilar steels, rolls, aluminium-forging dies, hot-work tools, dies for plastic and so on.

Classifications:	EN ISO 3581-A:E 29 9 R 1 2, SFA/AWS A5.4:(E312-17), EN 14700:E Fe11, Werkstoffnummer :1.4337
Approvals:	CE EN 13479, Seproz UNA 272580

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

Welding Current:	DC+, AC
Ferrite Content:	FN 30 - 50
Alloy Type:	Stainless duplex
Coating Type:	Acid Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As welded	500 MPa	750 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
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	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.0 x 300 mm	40-60 A	26 V	0.54	166	33 s	0.7 kg/h
2.5 x 300 mm	50-85 A	25 V	0.52	104	45 s	1.0 kg/h
3.2 x 350 mm	55-120 A	26 V	0.52	55	57 s	1.3 kg/h
4.0 x 350 mm	75-170 A	30 V	0.55	36	60 s	2.0 kg/h