

OK 67.15



Basic coated MMA-electrode for welding 25Cr 20Ni-steels. Also suitable for welding armour steels, austenitic manganese steels and for joining of dissimilar steels.

Specifications	
Classifications	EN ISO 3581-A : E 25 20 B 2 2 SFA/AWS A5.4 : E310-15 Werkstoffnummer : 1.4842
Approvals	CE : EN 13479 DB : 30.039.01 UKCA : EN 13479 VdTÜV : 01025

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

Welding Current	DC+
Ferrite Content	FN 0
Alloy Type	Austenitic CrNi
Coating Type	Lime Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	410 MPa	590 MPa	35 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C	100 J

Typical Weld Metal Analysis %				
C	Mn	Si	Ni	Cr
0.10	2.0	0.4	21.3	25.7

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.0 x 300 mm	45-55 A	24 V	62 %	36 sec	0.6 kg/h
2.5 x 300 mm	50-85 A	25 V	61 %	40 sec	0.9 kg/h
3.2 x 350 mm	60-115 A	25 V	59 %	60 sec	1.2 kg/h
4.0 x 350 mm	70-160 A	26 V	59 %	62 sec	1.8 kg/h
5.0 x 350 mm	130-200 A	26 V	60 %	65 sec	2.5 kg/h