

OK 67.55



OK 67.55 is a basic coated electrode especially designed for welding duplex stainless steels i, e. UNS S31803. The deposited weld metal gives very high ductility down to -50°C/-60°C. Particularly suitable for welding duplex pipes in offshore applications.

Classifications	SFA/AWS A5.4 : E2209-15 EN ISO 3581-A : E 22 9 3 N L B 2 2 Werkstoffnummer : 1.4462
Approvals	DNV-GL Duplex Seproz UNA 272580 VdTUV 06774

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

Welding Current	DC+
Ferrite Content	FN 35-50
Alloy Type	Austenitic CrNiMo
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	650 MPa (94 ksi)	800 MPa (116 ksi)	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C (68 °F)	100 J (74 ft-lb)
As Welded	-20 °C (-4 °F)	85 J (63 ft-lb)
As Welded	-40 °C (-40 °F)	75 J (56 ft-lb)
As Welded	-60 °C (-76 °F)	65 J (48 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.04	1.0	0.7	9.1	23.2	3.2	0.15	41

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Burn-off Time/ Electrode	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 300.0 mm (0.098 x 11.8 in.)	50-80 A	23 V	96	49 sec	59 %	0.8 kg/h (1.8 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	65-115 A	24 V	50	61 sec	59 %	1.2 kg/h (2.6 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	80-140 A	24 V	33	74 sec	60 %	1.5 kg/h (3.3 lb/h)