OK 67.13

OK 67.13 is an austenitic, stainless-steel electrode for welding 25Cr20Ni steels. The weld metal resists scaling up to 1100-1150°C and does not contain any measureable ferrite. OK 67.13 can also be used for welding certain air-hardening steels such as armour plate and for welding stainless to unalloyed steel.

Classifications	EN ISO 3581-A: E 25 20 R 1 2 SFA/AWS A5.4: E310-16 Werkstoffnummer : 1.4842

Welding Current	DC+, AC
Ferrite Content	FN 0
Alloy Type	Austenitic CrNi
Coating Type	Basic Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	430 MPa	600 MPa	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	20 °C	90 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
0.12	1.9	0.6	21.1	25.6

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
2.5 x 300 mm	50-85 A	21 V	0.51	101	42 sec	0.8 kg/h
3.2 x 350 mm	65-120 A	24 V	0.51	53	58 sec	1.2 kg/h
4.0 x 350 mm	70-160 A	28 V	0.51	34	61 sec	1.7 kg/h
5.0 x 350 mm	150-220 A	31 V	0.54	21	67 sec	2.6 kg/h

410039-en_GB-FactSheet_Main-01 2020-11-29