

OK 67.63



OK 67.63 is a rutile based, low carbon all positional electrode of 23Cr-13Ni type for joining of stainless steels to unalloyed or low alloyed steels. Also suitable for transition layers when surfacing mild or low alloyed steels with stainless steel weld metal.

Classifications:	SFA/AWS A5.4:E309L-16
Approvals:	PDIL E309L-16

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

Welding Current:	AC, DC+
Ferrite Content:	5-15 FN
Alloy Type:	Austenitic Cr-Ni
Coating Type:	Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	490 MPa	600 MPa	40 %

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
0.025	0.85	0.75	13.60	23.00

Current Range

Diameter	Current
2.5 x 350 mm	60-100 A
3.15 x 350 mm	80-120 A
4.0 x 350 mm	120-170 A
5.0 x 350 mm	160-210 A