

OK 68.17



OK 68.17 is a coated electrode designed for the welding of stainless-steel castings of the 13Cr4NiMo type, for example. OK 68.17 can be welded in all positions apart from vertical down.

Classifications	SFA/AWS A5.4 : E410NiMo-16 EN 14700 : E Fe7 EN ISO 3581-A : E 13 4 R 3 2 Werkstoffnummer : 1.4351
Approvals	Seproza UNA 272580

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

Welding Current	DC+, AC
Diffusible Hydrogen	<8.0 ml/100g
Alloy Type	Martensitic 13Cr4Ni-Mo type
Coating Type	Rutile Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
Stress Relieved 8hr 600°C (1112°F)	650 MPa (94 ksi)	870 MPa (126 ksi)	17 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
Stress Relieved 8hr 600°C (1112°F)	20 °C (68 °F)	45 J (33 ft-lb)
Stress Relieved 8hr 600°C (1112°F)	-10 °C (14 °F)	45 J (33 ft-lb)
Stress Relieved 8hr 600°C (1112°F)	-40 °C (-40 °F)	40 J (30 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.02	0.6	0.4	4.6	12.0	0.6

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 350.0 mm (0.098 x 13.8 in.)	55-100 A	21 V	73	61 sec	62 %	0.8 kg/h (1.8 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	65-135 A	21 V	45	66 sec	59 %	1.2 kg/h (2.6 lb/h)
4.0 x 450.0 mm (5/32 x 17.7 in.)	90-190 A	24 V	23	92 sec	59 %	1.7 kg/h (3.7 lb/h)