



Product Data Sheet

E 'Manual metal-arc welding'

OK 67.75

Prepared by A-C Thorsson	Qualified by P-O Oskarsson	Approved by Tapio Huhtala	Reg no EN007607	Cancelling EN007277	Reg date 2017-09-01	Page 1 (2)
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REASON FOR ISSUE

Maximum current for 3.2mm electrode increased from 110A to 120A.

GENERAL

Basic coated stainless steel electrode for welding steels of the type 24Cr 13Ni, welding transition layers when surfacing mild steel with stainless, joining dissimilar steels and welding root runs in the stainless side of clad steels.

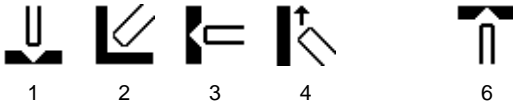
Polarity: DC+

Alloy Type: Austenitic CrNi

Coating Type: Basic

Ferrite Content: FN 8-15

WELDING POSITIONS



CLASSIFICATIONS Electrode

EN ISO 3581-A E 23 12 L B 4 2
SFA/AWS A5.4 E309L-15
Werkstoffnummer 1.4332

APPROVALS

ABS Stainless
DNV-GL VL 309
LR SS/CMn
NAKS/HAKC 2.5-5.0 mm
Seproz UNA 272580
VdTÜV 00633

APPROVAL COMMENT

NAKS/HAKC: Valid for lot numbers starting with SB

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max	Nom
C		0.04	
Si	0.20	0.70	
Mn	1.80	2.50	
P		0.025	
S		0.020	
Cr	23.0	25.0	
Ni	12.0	14.0	
Mo		0.50	
Cu		0.3	
N		0.08	
Ferrite FN			11



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MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO	AWS	
	As welded Min	As welded Min	Typ
Rp0.2 (MPa)	380	380	470
Rm (MPa)	520	520	600
A4 (%)		30	35
A5 (%)	30		
Z (%)		40	50
Charpy V at 20°C (J)	47	47	75
Charpy V at -50°C (J)		47	64
Charpy V at -80°C (J)	32	32	55

Comments:

Interpass temp. < 150 °C. Hardness all weld metal 190-230 HV.

ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 300	50	80	1.8	120	0.73	78	1.1	42	22	1,2,3,4,6
3.2 x 350	80	120	3.5	120	0.73	39	1.5	60	24	1,2,3,4,6
4.0 x 350	80	150	5.4	120	0.73	25	2.3	62	26	1,2,3,4,6
5.0 x 350	160	220	8.5	120	0.73	17	3.4	65	27	1,2

- W** = Weight (kg / 100 electrodes)
η = Efficiency (g weld metal x 100 / g core wire)
N = Effective value (kg weld metal / kg electrodes)
B = Changes (number of electrodes / kg weld metal)
H = Deposit rate at 90% of max current (kg weld metal / hour arc time)
T = Fusion time at 90% of max current (s / electrode)
U = Arc voltage (V)

OTHER DATA

Hardness data:
all weld metal in cladding application: 213 HV10

Redrying 200°C, 2h.