



# Product Data Sheet

E 'Manual metal-arc welding'

OK 69.33

Prepared by A-C Thorsson	Qualified by P-O Oskarsson	Approved by Tapio Huhtala	Reg no EN007474	Cancelling EN007141	Reg date 2017-02-22	Page 1 (2)
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## REASON FOR ISSUE

Maximum Ni and Mo content adjusted under chemical composition to fully align with AWS classification.

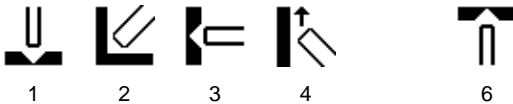
## GENERAL

Stainless steel electrode giving a fully austenitic weld metal highly resistant to sulphuric acid. The resistance to intergranular and pitting corrosion is good.

**Min AC OCV:** 65  
**Polarity:** AC, DC+

**Alloy Type:** Austenitic CrNi  
**Coating Type:** Basic Rutile  
**Ferrite Content:** FN 0

## WELDING POSITIONS



## CLASSIFICATIONS Electrode

EN ISO 3581-A    E 20 25 5 Cu N L R 3 2  
SFA/AWS A5.4    E385-16  
Werkstoffnummer    1.4519

## APPROVALS

CE                    EN 13479  
Seproz                UNA 272580  
VdTÜV                02723

## CHEMICAL COMPOSITION

	All Weld Metal (%)		
	Min	Max	Nom
C		0.03	
Si	0.20	0.70	
Mn	1.0	1.5	
P		0.030	
S		0.020	
Cr	19.5	21.5	
Ni	24.0	26.0	
Mo	4.20	5.20	
Cu	1.2	2.0	
N	0.05	0.15	
Ferrite FN			0



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## MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO		AWS
	Min	Typ	Min
As welded			As welded
Rp0.2 (MPa)	370	410	370
Rm (MPa)	530	590	530
A4 (%)			25
A5 (%)	25	35	
Z (%)		54	
Charpy V at 20°C (J)	47	80	
Charpy V at -140°C (J)	32	70	

### Comments:

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

## ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	$\eta$	N	B	H	T	U	Welding Positions
	Min	Max								
$\varnothing$ x Length										
2.5 x 300	60	85	1.8	110	0.60	91	0.9	44	24	1,2,3,4,6
3.2 x 350	85	130	4.2	120	0.58	41	1.5	60	27	1,2,3,4
4.0 x 350	95	180	6.6	115	0.51	30	1.9	64	29	1,2,3

- W** = Weight (kg / 100 electrodes)  
 **$\eta$**  = 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

Redrying: 250 °C, 2h.