

OK 67.15



Basic coated MMA-electrode for welding 25Cr 20Ni-steels. Also suitable for welding armour steels, austenitic manganese steels and for joining of dissimilar steels.

Classifications	SFA/AWS A5.4 : E310-15 EN ISO 3581-A : E 25 20 B 2 2 Werkstoffnummer : 1.4842
Approvals	CE EN 13479 DB 30.039.01 NAKS/HAKC 3.2MM Sepröz UNA 272580 VdTUV 01025

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

Welding Current	DC+
Ferrite Content	FN 0
Alloy Type	Austenitic CrNi
Coating Type	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	410 MPa	590 MPa	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C	100 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
0.10	2.0	0.4	21.3	25.7

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
2.0 x 300.0 mm	45-55 A	24 V	162	36 sec	62 %	0.6 kg/h
2.5 x 300.0 mm	50-85 A	25 V	96	40 sec	61 %	0.9 kg/h
3.2 x 350.0 mm	60-115 A	25 V	50	60 sec	59 %	1.2 kg/h
4.0 x 350.0 mm	70-160 A	26 V	28	62 sec	59 %	1.8 kg/h
5.0 x 350.0 mm	130-200 A	26 V	22	65 sec	60 %	2.5 kg/h