OK 68.53

Stainless MMA electrode for welding austenittic-ferritic stainless steels of the so called Superduplex types i.e. steel grade SAF 2507 and Zeron 100.

Classifications	SFA/AWS A5.4 : E2594-16 EN ISO 3581-A : E 25 9 4 N L R 32 Werkstoffnummer : (1.4410)
Approvals	CE EN 13479 DNV-GL Duplex VdTÜV 07377

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

Welding Current	DC+, AC
Ferrite Content	FN 35-50
Alloy Type	Austenitic-ferritic CrNiMo
Coating Type	Basic Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	700 MPa (102 ksi)	850 MPa (123 ksi)	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C (68 °F)	50 J (37 ft-lb)
As Welded	-40 °C (-40 °F)	40 J (30 ft-lb)

Typical Weld Metal Analysis %

C	Si	Ni	Cr	Mo	N	Ferrite FN
0.03	0.6	10.3	25.2	4	0.25	39

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 300.0 mm (0.098 x 11.8 in.)	55-85 A	22 V	94	43 sec	60 %	0.9 kg/h (2.0 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	70-110 A	22 V	47	62 sec	60 %	1.2 kg/h (2.6 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	80-150 A	23 V	32	67 sec	60 %	1.7 kg/h (3.7 lb/h)

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