

OK 69.33



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

Specifications

Classifications	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 UKCA : EN 13479 VdTÜV : 02723

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

Welding Current	AC, DC+
Ferrite Content	FN 0
Alloy Type	Austenitic CrNi
Coating Type	Basic Rutile
Min AC OCV	65

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	80 J
As Welded	-140 °C	70 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Cu	N	FN WRC-92
0.03	1.0	0.5	25.5	20.5	4.8	1.70	0.10	0

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300 mm	60-85 A	24 V	60 %	44 sec	0.9 kg/h
3.2 x 350 mm	85-130 A	27 V	58 %	60 sec	1.5 kg/h
4.0 x 350 mm	95-180 A	29 V	51 %	64 sec	1.9 kg/h