

OK 67.13



Austenitic stainless steel electrode for welding 25Cr20Ni steels. The weld metal does not contain any measureable ferrite and resists scaling up to 1100-1150 °C.

Specifications

Classifications	EN ISO 3581-A : E 25 20 R 1 2 SFA/AWS A5.4 : E310-16 Werkstoffnummer : 1.4842
Approvals	CE : EN 13479 UKCA : EN 13479

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

Welding Current	DC+, AC
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
AWS			
As Welded	430 MPa	600 MPa	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	20 °C	90 J
ISO		
As Welded	20 °C	83 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
0.12	1.9	0.6	21.1	25.6

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300 mm	50-85 A	21 V	51 %	42 sec	0.8 kg/h
3.2 x 350 mm	65-120 A	24 V	51 %	58 sec	1.2 kg/h
4.0 x 350 mm	70-160 A	28 V	51 %	61 sec	1.7 kg/h