

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.

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	430 MPa (62 ksi)	600 MPa (87 ksi)	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	20 °C (68 °F)	90 J (67 ft-lb)
ISO		
As Welded	20 °C (68 °F)	83 J (61 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
0.12	1.9	0.6	21.1	25.6

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.)	50-85 A	21 V	101	42 sec	51 %	0.8 kg/h (1.8 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	65-120 A	24 V	53	58 sec	51 %	1.2 kg/h (2.6 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	70-160 A	28 V	34	61 sec	51 %	1.7 kg/h (3.7 lb/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	150-220 A	31 V	21	67 sec	54 %	2.6 kg/h (5.7 lb/h)