

## OK 67.67



OK 67.67 is a rutile based, all positional electrode depositing a weld metal of the type 23Cr-13Ni. The weld deposit provides excellent resistance to corrosion and oxidation at very high temperatures, up to 1100°C.

<b>Classifications</b>	SFA/AWS A5.4 : E309/E309H-16
<b>Welding Current</b>	AC, DC+
<b>Ferrite Content</b>	5-15 FN
<b>Alloy Type</b>	Austenitic Cr-Ni
<b>Coating Type</b>	Rutile

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS</b>			
As Welded	480 MPa	590 MPa	35 %

### Current Range

Diameter	Current	Deposition Rate @ 90% I max
2.5 x 350.0 mm	60-100 A	0.0 kg/h
3.15 x 350.0 mm	80-120 A	0.0 kg/h
4.0 x 350.0 mm	120-170 A	0.0 kg/h