

OK 68.81

SMAW

OK 68.81 is a high-alloyed electrode which deposits a ferritic-austenitic duplex weld metal with approx. 40% ferrite. It is resistant to stress corrosion and is highly insensitive to dilution. Good scalling resistance up to 1150°C. OK 68.81 is used for joining dissimilar steels, steels with reduced weldability and buffer layers prior to hardfacing. Applications : rolls, forging dies, hot-work tools, dies for plastics and so on.

Welding Current

DC+, AC OCV 60 V



PACKING/ORDERING INFORMATION				
Part Number	Dia (mm)	Inner Carton (kg)	Carton Weight (kg)	Pallet Weight (kg)
VacPac				
68812020K0	2.0	0.6	5.4	415.8
68812520K0	2.5	0.7	6.3	485.1
68813230G0	3.2	1.7	10.2	683.4
68814030G0	4.0	1.8	10.8	723.6
68815030G0	5.0	1.7	10.2	683.4

CLASSIFICATIONS	TYPICAL ALL WELD METAL COMPOSITION (%)	TYPICAL MECH. PROPERTIES ALL WELD METAL
<u>SFA/AWS A5.4</u>	C 0.12	<u>Yield Stress, Mpa</u>
E312-17	Si 0.7	610
<u>EN 1600</u>	Mn 0.8	<u>Tensile Strength, MPa</u>
E 29 9 R 3 2	Cr 29.0	790
<u>Werkstoff Nr.</u>	Ni 9.8	<u>Elongation, %</u>
1.4337	Mo <0.5	22
	Cu <0.3	<u>Charpy V</u>
	Ferrite Content FN 50-80	Test Temps, °C Impact Values, J
		+20 30

WELDING PARAMETERS							
Diameter (mm)	Length (mm)	Welding Current, A	Arc Voltage, V	N. Kg Weld Metal/(kg) Electrodes	B. No. Of Electrodes/(kg) Weld Metal	H. Kg Weld Metal/(hour) Arc Time	T. Burn-off time, (secs)/ Electrode
2.0	300	35-60	22	0.64	123.0	0.7	41
2.5	300	50-85	24	0.64	78.0	0.9	48
3.2	350	80-125	25	0.62	42.0	1.3	65
4.0	350	110-175	26	0.62	26.0	2.0	66
5.0	350	150-240	28	0.65	16.5	3.2	68