

OK 67.68



A rutile-based electrode giving 23Cr/12Ni/ Cb stabilised deposit



Classification AWS A 5.4: E 309Cb-16
IS 5206: E 23.12 Cb R 26
DIN 8556: E 23 12 Cb R 23

DESCRIPTION

OK 67.68 is a rutile based electrode for depositing weldmetal that can withstand upto 1100°C in continuous service. The Cb stabilised 25/12 weldmetal provides resistance to intergranular corrosion and also provides higher strength for elevated temperature service. OK 67.68 provide excellent resistance to chemical corrosion and heat. The excellent arc and slag characteristics ensure smooth welding performance with an excellent finish coupled with high deposition efficiency.

WELDING CURRENT: DC +, AC 65V

TYPICAL APPLICATIONS

OK 67.68 is used for the welding of AISI 309 Cb type, straight chrome steels, joining stainless steels to low alloy steels and carbon steels. Also for building up on mild steel to improve wear resistance and for building up worn parts of wear resisting steels.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.07	Ni	12.5	UTS	590 N/mm ²
Mn	0.80	Si	0.60	YS	430 N/mm ²
Cr	24.0	Nb	0.80	EL (L=4d)	35%
S	0.015	P	0.020		

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	40-70	80	400
3.15	350	80-120	60	300
4.00	350	120-170	40	200
5.00	350	150-240	25	125

PACKING: Electrodes are packed in heat sealed plastic cartons and five of these cartons are shrink wrapped in a cardboard box.