

# OK 67.67



## A rutile type, 23% Cr 12% Ni type stainless steel electrode



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

### DESCRIPTION

OK 67.67 is a rutile based, medium coated, all position electrode depositing an alloy of 23 Cr, 12 Ni type which has excellent resistance to corrosion and oxidation at very high temperatures of up to 1100°C. OK 67.67 has an extremely stable and smooth arc with very easy striking and re-striking properties and a final slag that is self-peeling to reveal a very finely rippled, smooth and shiny bead. Welds are radiographically sound.

**APPROVALS:** PDIL, RDSO, NPC

**WELDING CURRENT:** DC +, AC 50V

### TYPICAL APPLICATIONS

OK 67.67 is particularly designed for applications requiring high strength and corrosion resistance at high temperatures of upto 1100°C; for e.g. welding of heat resistant chrome steels and Cr-Ni steels of the 309 type in low sulphurous atmospheres. It is also widely used for joining of dissimilar steels like joining of mild steel to stainless steel, low alloy steels to stainless steels for welding root runs in clad steels of 18/8 type. It is also used for surfacing to protect against severe environment e.g. on mild steel and wear resistant steels.

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.08	Si	0.70	YS	470 N/mm <sup>2</sup>
Mn	0.8	S	0.015	UTS	580 N/mm <sup>2</sup>
Cr	23.0	P	0.020	EL (L=4d)	35%
Ni	12.5				

### CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	60-90	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.