OK 67.43

Austenitic stainless steel MMA-electrode giving a weld metal of the CrNiMn-type. The weld metal, which contains a small amount of uniformly distributed ferrite, is tough and has an excellent crack resistance. Suitable for joining 13%Mn-steels and such steels to other steels. Also suitable for welding of other steels with very poor weldability.

Specifications	
Classifications	EN 14700 : E Fe10 EN ISO 3581-A : E 18 8 Mn R 1 2 SFA/AWS A5.4 : (E307-16) Werkstoffnummer : 1.4370
Approvals	CE : EN 13479 DB : 30.039.07 UKCA : EN 13479 VdTÜV : 06797

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+
Ferrite Content	FN <5
Alloy Type	Austenitic. CrNiMn
Coating Type	Rutile Basic
Min AC OCV	65

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	440 MPa (64 ksi)	630 MPa (91 ksi)	35 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	20 °C (68 °F)	80 J (59 ft-lb)
As Welded	-60 °C (-76 °F)	52 J (38 ft-lb)

Typical Weld Metal Analysis %						
C	**Mn**	**Si**	**Ni**	**Cr**	**N**	**FN WRC-92**
0.08	5.4	0.8	9.1	18.4	0.08	2

Deposition Data					
Diameter	**Current**	**Voltage**	**Deposition Efficiency (%)**	**Burn-off Time /Electrode**	**Deposition Rate @ 90% I max**
2.5 x 300 mm (0.098 x 11.8 in.)	60-80 A	22 V	51 %	46 sec	0.8 kg/h (1.8 lbs/h)
3.2 x 350 mm (1/8 x 13.8 in.)	90-115 A	23 V	54 %	54 sec	1.3 kg/h (2.9 lbs/h)
4.0 x 350 mm (5/32 x 13.8 in.)	100-150 A	23 V	56 %	61 sec	1.7 kg/h (3.7 lbs/h)
5.0 x 450 mm (0.197 x 17.7 in.)	130-210 A	24 V	60 %	86 sec	2.8 kg/h (6.2 lbs/h)