

OK 61.63

OK 61.63 is a rutile based low carbon 20Cr-10Ni type stainless steel electrode with controlled ferrite that provides excellent resistance to corrosion, cracking and high temperature scaling up to 800°C.

Specifications

Classifications	EN ISO 3581-A : E 19 9 L R 12 SFA/AWS A5.4 : E308L-16
Approvals	CE : EN 13479 PDIL : E308L-16

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

Welding Current	AC, DC+
Ferrite Content	3-8 FN
Alloy Type	Austenitic Cr-Ni
Coating Type	Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	470 MPa	610 MPa	42 %

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
0.025	0.65	0.85	10.00	20.00

Deposition Data

Diameter	Current
2.5 x 350.0 mm	60-90 A
3.15 x 350.0 mm	80-120 A
4.0 x 350.0 mm	120-170 A
5.0 x 350.0 mm	160-210 A