OK 61.80

OK 61.80 is a rutile type low carbon 19Cr-10Ni stabilized stainless steel electrode. Niobium minimizes the chromium carbide precipitation and thereby improves resistance to intergranular corrosion.

Specifications	
Classifications	SFA/AWS A5.4 : E347-16
Approvals	IBR : E347-16

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

Welding Current	AC, DC+
Ferrite Content	3-10 FN
Alloy Type	Austenitic Cr-Ni
Coating Type	Rutile

Typical Tensile Properties				
Condition	**Conditional Statement**	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS				
As Welded	As welded	500 MPa	630 MPa	35 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	20 °C	60 J
As Welded	0 °C	58 J
As Welded	-60 °C	40 J

Typical Weld Metal Analysis %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Nb**
0.03	0.65	0.90	9.80	19.80	0.65

Deposition Data	
Diameter	**Current**
2.5 x 350 mm	60-100 A
3.15 x 350 mm	80-120 A
4.0 x 350 mm	120-170 A