

OK 61.67

OK 61.67 is an AC/DC rutile coated 308 stainless steel electrode suitable for welding of types 304, 304H & similar alloys. The unique flux coating allows easy striking and restriking and is completely free from shortcircuiting during welding.

Specifications

Classifications	SFA/AWS A5.4 : E308/E308H-16
Welding Current	DC+, AC
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	630 MPa	42 %

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
0.05	0.75	0.80	9.10	20.50

Deposition Data

Diameter	Current
2.5 x 350.0 mm	60-100 A
3.15 x 350.0 mm	70-100 A
4.0 x 350.0 mm	120-170 A
5.0 x 350.0 mm	160-210 A