

OK 63.63

OK 63.63 is an extra low carbon, rutile based electrode depositing a weld metal of the type 316L. It has good corrosion resistance, particularly in acid and chlorinated environments.

Specifications

Classifications	SFA/AWS A5.4 : E316L-16 EN ISO 3581-B : ES316L-16
Approvals	CE : EN 13479 PDIL : E316L-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-Mo
Coating Type	Rutile

Typical Tensile Properties

Condition	Conditional Statement	Yield Strength	Tensile Strength	Elongation
AWS				
As Welded	As welded	500 MPa	580 MPa	40 %

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.03	0.60	0.85	12.00	18.30	2.30

Deposition Data

Diameter	Current
2.5 x 350.0 mm	60-100 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