OK 63.67

OK 63.67 is a rutile based stainless steel electrode suitable for welding of types 316, 316H & similar alloys used in applications involving high temperature service. Molybdenum provides creep resistance and ductility at elevated temperatures.

Specifications	
Classifications	SFA/AWS A5.4 : E316/E316H-16

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	600 MPa	40 %

Typical Weld Metal Analysis %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**
0.05	0.75	0.70	12.00	19.50	2.10

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