OK 61.25



Basic coated stainless electrode of the 308H-type especially designed for high temperature applications.

Specifications	
Classifications	EN ISO 3581-A : E 19 9 H B 2 2 SFA/AWS A5.4 : E308H-15

Welding Current	DC+
Ferrite Content	FN 2-5
Alloy Type	Austenitic CrNi
Coating Type	Basic

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	430 MPa	600 MPa	45 %
PWHT 1000 hour(s) 720 °C	300 MPa	570 MPa	45 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
AWS		
As Welded	20 °C	95 J
PWHT 1000 hour(s) 720 °C	20 °C	100 J
As Welded	-18 °C	83 J
As Welded	-40 °C	67 J

Typical Weld Metal Analysis %						
C	**Mn**	**Si**	**Ni**	**Cr**	**N**	**FN WRC-92**
0.06	1.7	0.3	9.8	18.8	0.06	4

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 300 mm	55-85 A	23 V	62 %	47 sec	0.9 kg/h
3.2 x 350 mm	75-110 A	23 V	59 %	66 sec	1.2 kg/h
4.0 x 350 mm	80-160 A	24 V	61 %	68 sec	1.8 kg/h