OK 61.30



Extra low carbon stainless steel electrode for welding steels of the 19 Cr 10 Ni-type. Also suitable for welding stabilized stainless steels of similar composition, except when the full creep resistance of the base material is to be met.

Specifications	
Classifications	EN ISO 3581-A : E 19 9 L R 1 2 SFA/AWS A5.4 : E308L-17 CSA W48 : E308L-17 Werkstoffnummer : 1.4316
Approvals	ABS : Stainless CE : EN 13479 CWB : E308L-17 DB : 30.039.02 DNV : NV 308 L UKCA : EN 13479 VdTÜV : 00792

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

Welding Current	DC+, AC
Ferrite Content	FN 3-10
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile
Min AC OCV	50

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	430 MPa	580 MPa	45 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
As Welded	20 °C	70 J
As Welded	-60 °C	49 J

Typical Weld Metal Analysis %						
C	**Mn**	**Si**	**Ni**	**Cr**	**N**	**FN WRC-92**
0.03	0.7	0.9	10.0	19.3	0.09	5

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
1.6 x 300 mm	35-45 A	27 V	55 %	24 sec	0.6 kg/h
2.0 x 300 mm	35-65 A	29 V	55 %	29 sec	0.8 kg/h
2.5 x 300 mm	50-90 A	31 V	55 %	36 sec	1.1 kg/h
3.2 x 350 mm	70-130 A	31 V	60 %	54 sec	1.4 kg/h
4.0 x 350 mm	90-180 A	32 V	60 %	60 sec	2.0 kg/h
5.0 x 350 mm	140-250 A	33 V	60 %	60 sec	3.0 kg/h