OK 61.81



Nb-stabilized MMA-electrode for welding Nb- or Ti-stabilized stainless steel of the 19Cr10Ni-type.

Specifications	
Classifications	EN ISO 3581-A : E 19 9 Nb R 3 2 SFA/AWS A5.4 : E347-16 Werkstoffnummer : 1.4551
Approvals	CE : EN 13479 DNV : NV 347 UKCA : EN 13479

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

Welding Current	DC+, AC
Ferrite Content	FN 6-12
Alloy Type	Austenitic CrNi
Coating Type	Rutile
Min AC OCV	60

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	560 MPa (81 ksi)	700 MPa (102 ksi)	31 %
ISO			
As Welded	550 MPa (80 ksi)	700 MPa (102 ksi)	-

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
AWS		
As Welded	20 °C (68 °F)	60 J (44 ft-lb)
ISO		
As Welded	-10 °C (14 °F)	71 J (53 ft-lb)

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**Ni**	**Cr**	**N**	**Nb**	**FN WRC-92**
0.06	1.7	0.7	9.7	20.2	0.08	0.72	7

Deposition Data					
Diameter	**Current**	**Voltage**	**Deposition Efficiency (%)**	**Burn-off Time /Electrode**	**Deposition Rate @ 90% I max**
2.5 x 300 mm (0.098 x 11.8 in.)	50-80 A	29 V	59 %	36 sec	1.2 kg/h (2.6 lbs/h)
3.2 x 350 mm (1/8 x 13.8 in.)	75-115 A	23 V	60 %	66 sec	1.2 kg/h (2.6 lbs/h)
4.0 x 350 mm (5/32 x 13.8 in.)	80-160 A	24 V	60 %	66 sec	1.7 kg/h (3.7 lbs/h)
5.0 x 350 mm (0.197 x 13.8 in.)	140-210 A	25 V	60 %	78 sec	2.3 kg/h (5.1 lbs/h)