OK 63.20



Rutile coated electrode for welding 18Cr12Ni3Mo -type steels. Also suitable for welding stabilized steels of similar composition. The electrode is especially designed for welding of thin walled pipes. Diameters 1.6 - 2.5mm. It can be used in all positions including vertical down.

Specifications	
Classifications	EN ISO 3581-A : E 19 12 3 L R 1 1 SFA/AWS A5.4 : E316L-16 CSA W48 : E316L-16 Werkstoffnummer : 1.4430
Approvals	CE : EN 13479 CWB : E316L-16 UKCA : EN 13479 VdTÜV : 09716

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

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

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	480 MPa	590 MPa	41 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
As Welded	20 °C	56 J
As Welded	-60 °C	46 J

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**N**	**FN WRC-92**
0.02	0.7	0.7	12.1	18.4	2.8	0.11	4

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
1.6 x 300 mm	15-40 A	23 V	63 %	53 sec	0.3 kg/h
2.0 x 300 mm	18-60 A	25 V	62 %	49 sec	0.5 kg/h
2.5 x 300 mm	25-80 A	22 V	63 %	54 sec	0.8 kg/h
3.2 x 350 mm	55-110 A	26 V	60 %	65 sec	1.2 kg/h