OK 63.30



Extra low carbon stainless steel electrode for welding steels of the 18Cr 12Ni 2.8Mo-type. Also suitable for welding of stabilized stainless steels of similar composition, except when the full creep resistance of the base metal is to be met.

Specifications	
Classifications	EN ISO 3581-A : E 19 12 3 L R 1 2 SFA/AWS A5.4 : E316L-17 CSA W48 : E316L-17 Werkstoffnummer : 1.4430
Approvals	ABS : E316L-17 BV : 316L CE : EN 13479 CWB : E316L-17 DB : 30.039.06 DNV : NV 316 L LR : 316L UKCA : EN 13479 VdTÜV : 00262

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	460 MPa	570 MPa	40 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
As Welded	20 °C	60 J
As Welded	-20 °C	55 J
As Welded	-60 °C	43 J

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**N**	**FN WRC-92**
0.02	0.6	0.8	11.0	18.1	2.6	0.10	6

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
1.6 x 300 mm	30-45 A	29 V	56 %	37 sec	0.4 kg/h
2.0 x 300 mm	45-65 A	29 V	60 %	39 sec	0.6 kg/h
2.5 x 300 mm	45-90 A	29 V	55 %	45 sec	0.9 kg/h
3.2 x 350 mm	60-125 A	30 V	55 %	57 sec	1.4 kg/h

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Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
4.0 x 350 mm	70-190 A	32 V	56 %	57 sec	2.0 kg/h
5.0 x 350 mm	100-280 A	32 V	56 %	63 sec	3.0 kg/h