

OK 63.30

Type Acid-rutile

SMAW

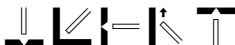
E316L-17

Description

OK 63.30 is an extra-low carbon, LMA electrode of the 18Cr12Ni2.8Mo type. It is also suitable for welding stabilised steels of similar composition, except when the full creep resistance of the base material has to be met. OK 63.30 is very easy to strike and restrike and produces weld beads with an excellent appearance and self-relieving slag.

Welding current

DC+, AC OCV 50 V



Classifications

EN 1600	E 19 12 3 L R 1 2
SFA/AWS A5.4	E316L-17
Werkstoff Nr.	1.4430
CSA W48	E316L-17

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	<0.9	0.9	18.0	12.0	2.8	<0.2

Typical mech. properties all weld metal

Yield stress, MPa	460
Tensile strength, MPa	570
Elongation A5, %	40

Charpy V

Test temps, °C	Impact values, J
+20	60
-20	55
-125	>32
Ferrite content	FN 3-10

Approvals

ABS	E316L-17	LR	316L
BV	U.P. for chemical applications	Sepron	UNA 409820
CL	EN 1600	SS	EN 1600
CWB	CSA W48	UDT	EN 1600
DB	30.039.06	VdTÜV	00262
DNV	316L	Ü	30.039
GL	4571		

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
1.6	300	35-50	29	0.56	250	0.4	37
2.0	300	45-65	29	0.60	147	0.6	39
2.5	300	60-90	29	0.55	96	0.9	45
2.5	350	60-90	30	0.56	83	1.1	41
3.2	350	80-125	30	0.55	52	1.4	57
4.0	350	120-170	32	0.56	34	2.0	57
5.0	350	150-240	32	0.56	21	3.0	63