OK 61.80

Type Acid-rutile

SMAW
E347-17

Description

OK 61.80 is a niobium-stabilised, stainless-steel, LMA electrode with low carbon content for welding stainless types 321 and 347. It is resistant to intergranular corrosion up to 400°C.

Welding current

DC+, AC OCV 50 V

Classifications

EN 1600	E 19 9 Nb R 1 2
SFA/AWS A5.4	E347-17
Werkstoff Nr.	1.4551

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Nb	Cu
<0.03	0.7	0.9	20.0	10.0	<0.3	<0.6	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	480
Tensile strength, MPa	620
Elongation A5, %	40

Charpy V

Test temps, °C	Impact values, J
+20	60
-80	40

Ferrite content FN 6-12

Approvals

GL	4550
UDT	EN 1600
VdTÜV	00638

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
2.0	300	45-65	24	0.56	150	0.7	35
2.5	300	60-90	26	0.56	97	1.0	38
3.2	350	80-120	28	0.56	50	1.4	53
4.0	350	120-170	30	0.56	33	2.0	55
5.0	350	150-240	31	0.56	21	2.9	60