

OK 61.80

Type Acid-rutile

SMAW

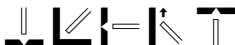
E347-17

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 |
| VdTUV | 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 |