

OK 61.81



Nb-stabilized MMA-electrode for welding Nb- or Ti-stabilized stainless steel of the 19Cr10Ni-type.

Classifications	SFA/AWS A5.4 : E347-16 EN ISO 3581-A : E 19 9 Nb R 3 2 Werkstoffnummer : 1.4551
Approvals	CE EN 13479 DNV-GL VL 347 NAKS/HAKC 3.2 mm

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

Welding Current	DC+, AC
Ferrite Content	FN 6-12
Alloy Type	Austenitic CrNi
Coating Type	Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	550 MPa (80 ksi)	700 MPa (102 ksi)	-
AWS			
As Welded	560 MPa (81 ksi)	700 MPa (102 ksi)	31 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-10 °C (14 °F)	71 J (53 ft-lb)
AWS		
As Welded	20 °C (68 °F)	60 J (44 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	N	Nb	Ferrite FN
0.06	1.7	0.7	9.7	20.2	0.08	0.72	7

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Burn-off Time/ Electrode	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 300.0 mm (0.098 x 11.8 in.)	50-80 A	29 V	82	36 sec	59 %	1.2 kg/h (2.6 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	75-115 A	23 V	44	66 sec	60 %	1.2 kg/h (2.6 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	80-160 A	24 V	32	66 sec	60 %	1.7 kg/h (3.7 lb/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	140-210 A	25 V	20	78 sec	60 %	2.3 kg/h (5.1 lb/h)