OK 63.80

Acid rutile covered MMA-electrode for welding Nb -or Ti-stabilized stainless steels of the CrNiMo 18-12-3 type.

Classifications	SFA/AWS A5.4 : E318-17 EN ISO 3581-A : E 19 12 3 Nb R 3 2 Werkstoffnummer : 1.4576
Approvals	CE EN 13479 NAKS/HAKC 2.5-3.2 mm VdTÜV 00639

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	Acid Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	507 MPa	614 MPa	38 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C	55 J
As Welded	-60 °C	41 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Nb	Ferrite FN
0.02	0.6	0.8	11.5	18.2	2.9	0.08	0.31	7

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
2.0 x 300.0 mm	45-65 A	29 V	155	29 sec	56 %	0.8 kg/h
2.5 x 300.0 mm	60-90 A	30 V	97	35 sec	56 %	1.1 kg/h
3.2 x 350.0 mm	80-120 A	32 V	48	54 sec	61 %	1.4 kg/h
4.0 x 350.0 mm	120-170 A	33 V	32	55 sec	61 %	2.1 kg/h

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