OK 61.20

Rutile coated electrode for welding 19Cr10Ni -type steels. Also suitable for welding stabilized steels of similar composition, except when the full creep resistance of the base material is to be met.
The electrode is especially designed for welding of thin walled pipes. Diameters 1.6 - 2.5mm can be used in all positions including vertical down.

Classifications	SFA/AWS A5.4 : E308L-16 EN ISO 3581-A : E 19 9 L R 1 1 Werkstoffnummer : 1.4316
Approvals	CE EN 13479 VdTÜV 10769

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

Welding Current	DC+, AC
Ferrite Content	FN 3 - 10
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	430 MPa	560 MPa	45 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C	70 J
As Welded	-50 °C	48 J
As Welded	-60 °C	38 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Cu	N	Ferrite FN
0.026	0.7	0.7	9.6	19.2	0.05	0.10	5

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
1.6 x 300.0 mm	23-40 A	23 V	227	53 sec	66 %	0.3 kg/h
2.0 x 300.0 mm	25-60 A	22 V	143	38 sec	66 %	0.7 kg/h
2.5 x 300.0 mm	28-85 A	22 V	93	44 sec	63 %	0.9 kg/h

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