

# OK 61.20



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

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

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

<b>Welding Current:</b>	DC+, AC
<b>Ferrite Content:</b>	FN 3 - 10
<b>Alloy Type:</b>	Austenitic CrNi
<b>Coating Type:</b>	Acid Rutile

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As welded	430 MPa	560 MPa	45 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
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	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
1.6 x 300 mm	23-40 A	23 V	0.66	227	53 s	0.3 kg/h
2.0 x 300 mm	25-60 A	22 V	0.66	143	38 s	0.7 kg/h
2.5 x 300 mm	28-85 A	22 V	0.63	93	44 s	0.9 kg/h