OK 63.35

OK 63.35 is a low carbon stainless steel electrode with basic coating of the 18Cr12Ni3Mo type. It is suitable for applications where the mechanical requirements are tough. It provides good impact toughness levels. Minimum lateral expansion of 0.38 mm requirement is met down to -120°C. The same requirement can be met at -196°C when the ferrite content is at the low end of the specification i.e. FN 3 - 4.

Classifications:	Werkstoffnummer :1.4430, SFA/AWS A5.4:E316L-15, EN ISO 3581-A:E 19 12 3 L B 2 2
Approvals:	CE EN 13479, Seproz UNA 272580, NAKS/HAKC 2.5-4.0 mm, ABS Stainless, VdTÜV 04812

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

Welding Current:	DC+
Ferrite Content:	FN 3-8
Alloy Type:	Austenitic CrNi
Coating Type:	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As welded	430 MPa	560 MPa	40 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As welded	20 °C	95 J
As welded	-60 °C	75 J
As welded	-120 °C	60 J
As welded	-196 °C	35 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.04	1.6	0.4	12.6	18.3	2.7	0.06	4

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
2.5 x 300 mm	55-85 A	24 V	0.63	91	42 s	0.9 kg/h
3.2 x 350 mm	80-120 A	24 V	0.63	47	58 s	1.3 kg/h
4.0 x 350 mm	80-180 A	24 V	0.62	32	63 s	1.8 kg/h