

## OK 62.53

Rutile coated stainless electrode especially designed for heat resisting applications. The weld metal has a scaling temperature of about 1150 °C. OK 62.53 is recommended for welding of Avesta 253 MA, steels like AISI 309 and W.Nr 1.4828. The core wire contains Ce.

### Specifications

<b>Classifications</b>	EN ISO 3581-A : E Z 23 10 N R 12
<b>Approvals</b>	CE : EN 13479 UKCA : EN 13479

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

<b>Welding Current</b>	AC, DC+
<b>Ferrite Content</b>	FN 4-8
<b>Alloy Type</b>	CrNi stainless
<b>Coating Type</b>	Rutile

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	550 MPa	730 MPa	35 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As Welded	20 °C	60 J

### Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	N	Ferrite FN
0.07	0.6	1.6	10.4	23.1	0.16	6

### Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300.0 mm	50-90 A	26 V	55 %	44 sec	0.8 kg/h
3.2 x 350.0 mm	70-110 A	25 V	55 %	66 sec	1.0 kg/h