

OK 61.25

Basic coated stainless electrode of the 308H-type especially designed for high temperature applications.

Specifications

Classifications	EN ISO 3581-A : E 19 9 H B 2 2 SFA/AWS A5.4 : E308H-15
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Welding Current	DC+
Ferrite Content	FN 2-5
Alloy Type	Austenitic CrNi
Coating Type	Basic

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	430 MPa	600 MPa	45 %
PWHT 1000 hour(s) 720 °C	300 MPa	570 MPa	45 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
AWS		
As Welded	-18 °C	83 J
PWHT	20 °C	100 J
As Welded	20 °C	95 J
As Welded	-40 °C	67 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	N	Ferrite FN
0.06	1.7	0.3	9.8	18.8	0.06	4

Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 300.0 mm	55-85 A	23 V	62 %	47 sec	0.9 kg/h
3.2 x 350.0 mm	75-110 A	23 V	59 %	66 sec	1.2 kg/h
4.0 x 350.0 mm	80-160 A	24 V	61 %	68 sec	1.8 kg/h