

OK 61.30

Extra-low carbon stainless steel electrode for welding steels of the 19 Cr 10 Ni-type. Also suitable for welding stabilized stainless steels of similar composition, except when full creep resistance of the base material is to be met.

Specifications	
Classifications	CSA W48 : E 308L-17 EN 1600 : E 19 9 L R 1 2 SFA/AWS A5.4 : E308L-17 Werkstoff Nr. : 1.4316
Approvals	ABS Stainless CE EN 13479 CWB CSA W48 DB 30.039.02 DNV 308L Sepros UNA 272580 VdTÜV 00792

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			
Conditional Statement	Yield Strength	Tensile Strength	Elongation
As welded	430 MPa (62.3 ksi)	580 MPa (84.1 ksi)	45 %

Typical Charpy V-Notch Properties	
Testing Temperature	Impact Value
20 °C (68 °F)	70 J (52 ft-lb)
-60 °C (-76 °F)	49 J (36 ft-lb)

Deposition Data						
Diameter	Current	Voltage	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Burn-off Time /Electrode	Deposition Rate
1.6 x 300 mm (1/16 x 12 in.)	35-45 A	27 V	0.55	240	24 sec	0.6 kg/h (1.3 lbs/h)
2.0 x 300 mm (5/64 x 12 in.)	35-65 A	29 V	0.55	160	29 sec	0.8 kg/h (1.8 lbs/h)
2.5 x 300 mm (3/32 x 12 in.)	50-90 A	31 V	0.55	99	36 sec	1.1 kg/h (2.4 lbs/h)
3.2 x 350 mm (1/8 x 14 in.)	70-130 A	31 V	0.60	49	54 sec	1.4 kg/h (3.1 lbs/h)
4.0 x 350 mm (5/32 x 14 in.)	90-180 A	32 V	0.60	33	60 sec	2.0 kg/h (4.4 lbs/h)
5.0 x 350 mm (3/16 x 14 in.)	140-250 A	33 V	0.60	20	60 sec	3.0 kg/h (6.6 lbs/h)