

OK 61.35

OK 61.35 is a basic, low-carbon, stainless electrode of the E308L type with very good welding properties in the vertical and overhead positions. The high impact toughness at cryogenic temperature (-196°C) makes OK 61.35 excellent in LNG applications.

Specifications	
Classifications	EN 1600 : E 19 9 L B 2 2 SFA/AWS A5.4 : E308L-15 Werkstoff Nr. : 1.4316
Approvals	Sepros UNA 409820 UDT EN 1600 VdTÜV 04811

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

Welding Current	DC+
Ferrite Content	FN 4-8
Alloy Type	Austenitic CrNi
Coating Type	Basic

Typical Tensile Properties			
Conditional Statement	Yield Strength	Tensile Strength	Elongation
As welded	445 MPa (64.5 ksi)	610 MPa (88.5 ksi)	44 %

Typical Charpy V-Notch Properties	
Testing Temperature	Impact Value
20 °C (68 °F)	100 J (74 ft-lb)
-120 °C (184 °F)	70 J (52 ft-lb)
-196 °C (-321 °F)	40 J (29.5 ft-lb)

Deposition Data						
Diameter	Current	Voltage	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Burn-off Time /Electrode	Deposition Rate
2.5 x 300 mm (3/32 x 12 in.)	55-85 A	22 V	0.61	92	37 sec	0.9 kg/h (2.0 lbs/h)
3.2 x 350 mm (1/8 x 14 in.)	80-120 A	25 V	0.61	50	54 sec	1.3 kg/h (2.9 lbs/h)
4.0 x 350 mm (5/32 x 14 in.)	80-180 A	27 V	0.61	33	58 sec	1.9 kg/h (4.2 lbs/h)
5.0 x 350 mm (3/16 x 14 in.)	160-210 A	26 V	0.58	22	70 sec	2.3 kg/h (5.1 lbs/h)