

OK 61.80

OK 61.80 is a niobium-stabilised, stainless-steel, LMA electrode with low carbon content for welding stainless types 321 and 347. It is resistant to intergranular corrosion up to 400°C.

Specifications	
Classifications	EN 1600 : E 19 9 Nb R 1 2 SFA/AWS A5.4 : E347-17 Werkstoff Nr. : 1.4551
Approvals	CE EN 13479 GL 4550 VdTÜV 00638

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

Welding Current	DC+, AC
Ferrite Content	FN 6-12
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile

Typical Tensile Properties			
Conditional Statement	Yield Strength	Tensile Strength	Elongation
As welded	480 MPa (69.6 ksi)	620 MPa (89.9 ksi)	40 %

Typical Charpy V-Notch Properties	
Testing Temperature	Impact Value
20 °C (68 °F)	60 J (44 ft-lb)
-60 °C (-76 °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.)	50-90 A	26 V	0.56	97	38 sec	1.0 kg/h (2.2 lbs/h)
3.2 x 350 mm (1/8 x 14 in.)	70-130 A	28 V	0.56	50	53 sec	1.4 kg/h (3.1 lbs/h)
4.0 x 350 mm (5/32 x 14 in.)	90-180 A	30 V	0.56	33	55 sec	2.0 kg/h (4.4 lbs/h)
5.0 x 350 mm (3/16 x 14 in.)	140-250 A	31 V	0.56	21	60 sec	2.9 kg/h (6.4 lbs/h)