

OK 63.20

Rutile coated electrode for welding 18Cr12Ni3Mo -type steels. Also suitable for welding stabilized steels of similar composition. The electrode is especially designed for welding of thin walled pipes. Diameters 1.6 - 2.5mm. It can be used in all positions including vertical down.

Specifications	
Classifications	CSA W48 : E316L-16 EN 1600 : E 19 12 3 L R 1 1 SFA/AWS A5.4 : E316L-16 Werkstoff Nr : 1.4430
Approvals	CE EN 13479 CWB CSA W48 Sepros UNA 272580 VdTÜV 09716

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

Welding Current	DC+, AC
Ferrite Content	FN 3-10
Alloy Type	Austenitic CrNiMo
Coating Type	Acid Rutile

Typical Tensile Properties			
Conditional Statement	Yield Strength	Tensile Strength	Elongation
As welded	480 MPa (69.6 ksi)	590 MPa (85.6 ksi)	41 %

Typical Charpy V-Notch Properties	
Testing Temperature	Impact Value
20 °C (68 °F)	56 J (41 ft-lb)
-60 °C (-76 °F)	46 J (34 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.)	15-40 A	23 V	0.63	227	53 sec	0.3 kg/h (0.7 lbs/h)
2.0 x 265 mm (5/64 x 10 in.)	18-60 A	22 V	0.65	167	44 sec	0.6 kg/h (1.3 lbs/h)
2.0 x 300 mm (5/64 x 12 in.)	18-60 A	25 V	0.62	152	49 sec	0.5 kg/h (1.1 lbs/h)
2.5 x 300 mm (3/32 x 12 in.)	25-80 A	22 V	0.63	96	54 sec	0.8 kg/h (1.8 lbs/h)
3.2 x 350 mm (1/8 x 14 in.)	55-110 A	26 V	0.60	52	65 sec	1.2 kg/h (2.6 lbs/h)