

OK 63.30

Extra low carbon stainless steel electrode for welding steels of the 18Cr 12Ni 2.8Mo-type. Also suitable for welding of stabilized stainless steels of similar composition, except when the full creep resistance of the base metal is to be met.

Specifications	
Classifications	EN ISO 3581-A : E 19 12 3 L R 1 2 SFA/AWS A5.4 : E316L-17 CSA W48 : E316L-17 Werkstoffnummer : 1.4430
Approvals	ABS : E316L-17 BV : 316L CE : EN 13479 CWB : E316L-17 DB : 30.039.06 DNV-GL : VL 316 L LR : 316L UKCA : EN 13479 VdTÜV : 00262

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	460 MPa (66.7 ksi)	570 MPa (82.7 ksi)	40 %

Typical Charpy V-Notch Properties	
Testing Temperature	Impact Value
20 °C (68 °F)	60 J (44 ft-lb)
-20 °C (-4 °F)	55 J (40.5 ft-lb)
-60 °C (-76 °F)	43 J (32 ft-lb)

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	N	FN WRC-92
0.02	0.6	0.8	11.0	18.1	2.6	0.10	6

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.)	30-45 A	29 V	0.56	250	37 sec	0.4 kg/h (0.8 lbs/h)
2.0 x 300 mm (5/64 x 12 in.)	45-65 A	29 V	0.60	147	39 sec	0.6 kg/h (1.3 lbs/h)
2.5 x 300 mm (3/32 x 12 in.)	45-90 A	29 V	0.55	96	45 sec	0.9 kg/h (2.0 lbs/h)
3.2 x 350 mm (1/8 x 14 in.)	60-125 A	30 V	0.55	52	57 sec	1.4 kg/h (3.1 lbs/h)

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Deposition Data

Diameter	Current	Voltage	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Burn-off Time /Electrode	Deposition Rate
4.0 x 350 mm (5/32 x 14 in.)	70-190 A	32 V	0.56	34	57 sec	2.0 kg/h (4.4 lbs/h)
5.0 x 350 mm (3/16 x 14 in.)	100-280 A	32 V	0.56	21	63 sec	3.0 kg/h (6.6 lbs/h)