OK 63.34

OK 63.34 is a rutile MMA-electrode of the 19Cr 12Ni 3Mo-type designed for vertical down welding of steels of similar composition. It provides beads with a very good finish and good tie in profiles to the joint edges.

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	CWB CSA W48 Seproz UNA 272580 VdTÜV 02311 VdTÜV 03816

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

Welding Current	DC+, AC
Ferrite Content	FN 3-8
Alloy Type	Austenitic CrNiMo
Coating Type	Acid Rutile

Typical Tensile Properties			
Conditional Statement	**Yield Strength**	**Tensile Strength**	**Elongation**
As welded	440 MPa (63.8 ksi)	600 MPa (87 ksi)	40 %

Typical Charpy V-Notch Properties	
Testing Temperature	**Impact Value**
-120 °C (-184 °F)	38 J (28 ft-lb)
20 °C (68 °F)	65 J (48 ft-lb)
-20 °C (-4 °F)	52 J (38 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.)	70-90 A	22 V	0.70	94	39 sec	1.0 kg/h (2.2 lbs/h)
3.2 x 300 mm (1/8 x 12 in.)	80-130 A	25 V	0.70	59	39 sec	1.6 kg/h (3.5 lbs/h)