

OK 64.30

OK 64.30 is an acid-rutile electrode for welding 19Cr 13Ni 3.5Mo (317L) austenitic stainless steels. The high Mo content provides better resistance to acid and pitting corrosion compared with 316L types. OK 64.30 is easy to weld in all positions and yields smooth runs on both AC and DC.

Specifications

Classifications	EN 1600 : E Z 19 13 4 N L R 3 2 SFA/AWS A5.4 : E317L-17 Werkstoff Nr. : (1.4447)
Approvals	VdTÜV : 02311

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

Welding Current	DC+, AC
Ferrite Content	FN 5-10
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)	600 MPa (87 ksi)	35 %

Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
20 °C (68 °F)	45 J (33 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.)	50-80 A	29 V	0.56	94	52 sec	0.8 kg/h (1.8 lbs/h)
3.2 x 350 mm (1/8 x 14 in.)	60-120 A	30 V	0.56	51	52 sec	1.4 kg/h (3.1 lbs/h)
4.0 x 350 mm (5/32 x 14 in.)	80-170 A	32 V	0.56	33	58 sec	2.1 kg/h (4.6 lbs/h)