OK 61.25

OK 61.25 is a basic coated, stainless-steel electrode of the 308H type. The electrode is designed for high-temperature applications in petrochemical and chemical process plants.

Specifications	
Classifications	EN ISO 3581-A : E 19 9 H B 2 2 SFA/AWS A5.4 : E308H-15

Welding Current	DC+
Ferrite Content	FN 2-5
Alloy Type	Austenitic CrNi
Coating Type	Basic

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	430 MPa (62 ksi)	600 MPa (87 ksi)	45 %
PWHT 1000 hour(s) 720 °C (1328 °F)	300 MPa (44 ksi)	570 MPa (83 ksi)	45 %

Typical Charpy V-Notch Properties	
Testing Temperature	**Impact Value**
AWS	
-18 °C (-0.4 °F)	83 J (61 ft-lb)
20 °C (68 °F)	95 J (70 ft-lb)
20 °C (68 °F)	100 J (74 ft-lb)

Deposition Data					
Diameter	**Current**	**Voltage**	**Deposition Efficiency (%)**	**Burn-off Time /Electrode**	**Deposition Rate @ 90% I max**
2.5 x 300.0 mm (0.098 x 11.8 in.)	55-85 A	23 V	62 %	47 sec	0.9 kg/h (2.0 lbs/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	75-110 A	23 V	59 %	66 sec	1.2 kg/h (2.6 lbs/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	80-160 A	24 V	61 %	68 sec	1.8 kg/h (4.0 lbs/h)