

OK 61.35

Basic stainless electrode of the 308L-type designed for positional welding such as piping. Suitable for applications where requirements concerning mechanical properties are demanding. Lateral expansion of min. 0.38 mm is met down to -120 °C.

Specifications	
Classifications	EN ISO 3581-A : E 19 9 L B 2 2 SFA/AWS A5.4 : E308L-15 Werkstoffnummer : 1.4316
Approvals	CE : EN 13479 NAKS/HAKC : 2.5-5.0 mm UKCA : EN 13479 VdTÜV : 04811

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

Welding Current	DC+
Ferrite Content	FN 4-8
Alloy Type	Austenitic CrNi
Coating Type	Basic

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	445 MPa	610 MPa	44 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
AWS		
As Welded	-196 °C	40 J
ISO		
As Welded	-120 °C	70 J
As Welded	20 °C	100 J
As Welded	-196 °C	40 J

Typical Weld Metal Analysis %						
C	Mn	Si	Ni	Cr	N	Ferrite FN
0.04	1.6	0.3	9.8	19.5	0.06	6

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 300.0 mm	55-85 A	22 V	61 %	37 sec	0.9 kg/h
3.2 x 350.0 mm	80-120 A	25 V	61 %	54 sec	1.3 kg/h
4.0 x 350.0 mm	80-180 A	27 V	61 %	58 sec	1.9 kg/h