OK 61.20

Rutile coated electrode for welding 19Cr10Ni -type steels. Also suitable for welding stabilized steels of similar composition, except when the full creep resistance of the base material is to be met. The electrode is especially designed for welding of thin walled pipes. It can be used in all positions including vertical down.

Specifications	
Classifications	EN ISO 3581-A : E 19 9 L R 1 1 SFA/AWS A5.4 : E308L-16 Werkstoffnummer : 1.4316
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 10769

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

Welding Current	DC+, AC
Ferrite Content	FN 3 - 10
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	430 MPa	560 MPa	45 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	-60 °C	38 J
As Welded	-50 °C	48 J
As Welded	20 °C	70 J

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**Ni**	**Cr**	**Cu**	**N**	**FN WRC-92**
0.026	0.7	0.7	9.6	19.2	0.05	0.10	5

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.0 x 300.0 mm	25-60 A	22 V	66 %	38 sec	0.7 kg/h
2.5 x 300.0 mm	28-85 A	22 V	63 %	44 sec	0.9 kg/h