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	EN ISO 3581-A : E 19 12 3 L R 1 1 SFA/AWS A5.4 : E316L-16 CSA W48 : E316L-16 Werkstoffnummer : 1.4430
Approvals	CWB : E316L-16 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			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	440 MPa	600 MPa	40 %
ISO			
As Welded	440 MPa	600 MPa	

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
AWS		
As Welded	-20 °C	52 J
As Welded	20 °C	65 J
ISO		
As Welded	-120 °C	38 J
As Welded	20 °C	65 J

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**N**	**Ferrite FN**
0.02	0.8	0.8	11.8	18.7	2.8	0.13	6

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 300.0 mm	70-90 A	22 V	70 %	39 sec	1.0 kg/h
3.2 x 300.0 mm	80-130 A	25 V	70 %	39 sec	1.6 kg/h