

OK 64.63

OK 64.63 is a stainless electrode which deposits a fully austenitic (non-magnetic) weld metal of the CrNiMo type with very good corrosion resistance. It has excellent welding characteristics in all positions apart from vertical down.

Specifications

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| Classifications | EN 1600 : E 18 16 5 N L R 3 2 Werkstoff Nr. : 1.4440 |
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Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|-----------|----------------|------------------|------------|
| As Welded | 480 MPa | 640 MPa | 35 % |

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|-----------|---------------------|--------------|
| As Welded | +20 °C | 75 J |

Deposition Data

| Diameter | Current | Voltage | Efficiency (%) |
|----------|-----------|---------|----------------|
| 4 mm | 110-150 A | 22 V | 114-120 % |
| 3.2 mm | 80-110 A | 22 V | 114-120 % |