

OK 63.85

Basic MMA-electrode for welding Nb-stabilized stainless steels of 18Cr 12Ni 3Mo-type.

Specifications

Classifications	EN ISO 3581-A : E 19 12 3 Nb B 42 SFA/AWS A5.4 : E318-15 Werkstoffnummer : 1.4576
Approvals	VdTÜV : 05662

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

Welding Current	DC+
Ferrite Content	FN 5-10
Alloy Type	Nb-stabilized austenitic CrNiMo-type
Coating Type	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	490 MPa	640 MPa	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	-120 °C	45 J
As Welded	20 °C	65 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Nb	FN WRC-92
0.04	1.6	0.5	13.0	17.9	2.7	0.06	0.55	5

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300.0 mm	50-80 A	22 V	66 %	45 sec	1.0 kg/h
3.2 x 350.0 mm	65-120 A	23 V	64 %	58 sec	1.5 kg/h