

OK 61.35 Cryo

A basic stainless stick electrode of the 308L-type especially designed for cryogenic applications. Provides controlled low ferrite content to ensure lateral expansion of min. 0.38 mm at -196°C.

Specifications

Classifications	EN ISO 3581-A : E 19 9 L B 2 2 SFA/AWS A5.4 : E308L-15 Werkstoffnummer : 1.4316
Approvals	VdTÜV : 10721

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

Welding Current	DC+
Ferrite Content	FN 2-4
Alloy Type	Austenitic CrNi
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	425 MPa	580 MPa	45 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	20 °C	100 J
As Welded	-196 °C	43 J
ISO		
As Welded	-196 °C	43 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	N	FN WRC-92
0.04	1.6	0.3	10.5	18.7	0.06	3

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
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
5.0 x 350.0 mm	160-210 A	26 V	58 %	70 sec	2.3 kg/h