

OK 61.85

Nb-stabilized basic coated electrode designed for welding of Nb- or Ti-stabilized stainless steels of the 19Cr10Ni-type. OK 61.85 provides the best hot cracking resistance of the products belonging to the 347 range. Due to the relatively high ferrite content level, the maximum working temperature should be limited to 400°C.

Specifications

Classifications	EN ISO 3581-A : E 19 9 Nb B 2 2 SFA/AWS A5.4 : E347-15 Werkstoffnummer : 1.4551
Approvals	VdTÜV : 05663

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

Welding Current	DC+
Ferrite Content	FN 6-12
Alloy Type	Austenitic CrNi
Coating Type	Basic

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
Stress Relieved 16 hour(s) 600 °C	500 MPa	640 MPa	40 %
As Welded	500 MPa	620 MPa	40 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
ISO		
Stress Relieved	-60 °C	40 J
As Welded	20 °C	100 J
As Welded	-60 °C	70 J
Stress Relieved	20 °C	80 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	N	Nb	FN WRC-92
0.04	1.7	0.4	10.2	19.5	0.07	0.61	8

Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 300.0 mm	55-80 A	25 V	60 %	42 sec	0.9 kg/h
3.2 x 350.0 mm	75-110 A	23 V	62 %	64 sec	1.2 kg/h
4.0 x 350.0 mm	80-150 A	24 V	61 %	70 sec	1.6 kg/h
5.0 x 350.0 mm	150-200 A	23 V	61 %	76 sec	2.3 kg/h