

OK 63.41

High-efficiency low carbon stainless steel electrode for welding steels of the type 18 Cr 12 Ni 2-3 Mo.

Specifications	
Classifications	EN ISO 3581-A : E 19 12 3 L R 5 3 SFA/AWS A5.4 : E316L-26 Werkstoffnummer : 1.4430
Approvals	CE : EN 13479 DNV-GL : VL 316 L LR : 316LN UKCA : EN 13479 VdTÜV : 01014

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

Welding Current	AC, DC+
Ferrite Content	FN 3-8
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	470 MPa	570 MPa	35 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C	60 J
As Welded	-60 °C	52 J

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	N	FN WRC-92
0.03	0.7	0.8	12.5	18.2	2.9	0.09	4

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300.0 mm	60-90 A	34 V	61 %	35 sec	1.6 kg/h
3.2 x 350.0 mm	80-130 A	36 V	58 %	50 sec	2.1 kg/h
4.0 x 450.0 mm	110-180 A	37 V	60 %	70 sec	2.9 kg/h
5.0 x 450.0 mm	170-240 A	42 V	61 %	82 sec	4.0 kg/h