

OK 64.30

OK 64.30 is a low carbon rutile covered electrode for welding of 19Cr 13Ni 3-4Mo- type stainless steel. The higher molybdenum content provides a higher pitting corrosion resistance than E316L types.

Specifications

Classifications	EN ISO 3581-A : E Z 19 13 4 N L R 3 2 SFA/AWS A5.4 : E317L-17 Werkstoffnummer : (1.4447)
Approvals	VdTÜV : 02311

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

Welding Current	DC+, AC
Ferrite Content	FN 5-10
Alloy Type	Austenitic CrNiMo
Coating Type	Acid Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	480 MPa	600 MPa	35 %
ISO			
As Welded	480 MPa	600 MPa	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-20 °C	46 J
As Welded	20 °C	49 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	FN WRC-92
0.02	0.7	0.7	13.1	18.4	3.6	0.08	8

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	29 V	56 %	52 sec	0.8 kg/h
3.2 x 350.0 mm	60-120 A	30 V	56 %	52 sec	1.4 kg/h
4.0 x 350.0 mm	80-170 A	32 V	56 %	58 sec	2.1 kg/h