

OK 63.35

OK 63.35 is a low carbon stainless steel electrode with basic coating of the 18Cr12Ni3Mo type. It is suitable for applications where the mechanical requirements are tough. It provides good impact toughness levels. Minimum lateral expansion of 0.38mm requirement is met down to -120°C. The same requirement can be met at -196°C when the ferrite content is at the low end of the specification i.e. FN 3 - 4.

Specifications	
Classifications	EN ISO 3581-A : E 19 12 3 L B 2 2 SFA/AWS A5.4 : E316L-15 Werkstoffnummer : 1.4430
Approvals	ABS : Stainless CE : EN 13479 UKCA : EN 13479 VdTÜV : 04812

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

Welding Current	DC+
Ferrite Content	FN 3-8
Alloy Type	Austenitic CrNi
Coating Type	Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	430 MPa	560 MPa	40 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS		
As Welded	-120 °C	60 J
As Welded	20 °C	95 J
As Welded	-196 °C	35 J
As Welded	-60 °C	75 J

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	N	FN WRC-92
0.04	1.6	0.4	12.6	18.3	2.7	0.06	4

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	24 V	63 %	42 sec	0.9 kg/h
3.2 x 350.0 mm	80-120 A	24 V	63 %	58 sec	1.3 kg/h
4.0 x 350.0 mm	80-180 A	24 V	62 %	63 sec	1.8 kg/h