

OK 64.63

OK 64.63 is a stainless electrode which deposits a fully austenitic (non-magnetic) weld metal of the CrNiMo type with very good corrosion resistance. It has excellent welding characteristics in all positions apart from vertical down.

Specifications

Classifications	EN 1600 : E 18 16 5 N L R 3 2 Werkstoff Nr. : 1.4440
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	480 MPa	640 MPa	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	+20 °C	75 J

Deposition Data

Diameter	Current	Voltage	Efficiency (%)
4 mm	110-150 A	22 V	114-120 %
3.2 mm	80-110 A	22 V	114-120 %