OK 61.50

OK 61.50 is a stainless steel electrode for welding of 19Cr 9 Ni austenitic stainless steels with a carbon content >0.04%. Especially designed for high temperature applications.

Specifications	
Classifications	EN ISO 3581-A : E 19 9 H R 1 2 SFA/AWS A5.4 : E308H-17

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

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	430 MPa	600 MPa	45 %

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

Typical Weld Metal Analysis %						
C	**Mn**	**Si**	**Ni**	**Cr**	**N**	**FN WRC-92**
0.05	0.7	0.7	10.0	19.8	0.10	4

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 300.0 mm	50-85 A	27 V	56 %	42 sec	0.9 kg/h
3.2 x 350.0 mm	70-110 A	27 V	56 %	63 sec	1.1 kg/h
4.0 x 350.0 mm	110-165 A	28 V	56 %	62 sec	1.7 kg/h