

OK 61.35 Cryo

A basic stainless stick electrode of the 308L-type especially designed for cryogenic applications. Provides controlled low ferrite content to ensure lateral expansion of min. 0.38 mm at -196°C.

Specifications

| | |
|------------------------|---|
| Classifications | EN ISO 3581-A : E 19 9 L B 2 2 SFA/AWS A5.4 : E308L-15 Werkstoffnummer : 1.4316 |
| Approvals | VdTÜV : 10721 |

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

| | |
|------------------------|-----------------|
| Welding Current | DC+ |
| Ferrite Content | FN 2-4 |
| Alloy Type | Austenitic CrNi |
| Coating Type | Basic |

Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|------------|----------------|------------------|------------|
| AWS | | | |
| As Welded | 425 MPa | 580 MPa | 45 % |

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|------------|---------------------|--------------|
| AWS | | |
| As Welded | 20 °C | 100 J |
| As Welded | -196 °C | 43 J |
| ISO | | |
| As Welded | -196 °C | 43 J |

Typical Weld Metal Analysis %

| C | Mn | Si | Ni | Cr | N | FN WRC-92 |
|------|-----|-----|------|------|------|-----------|
| 0.04 | 1.6 | 0.3 | 10.5 | 18.7 | 0.06 | 3 |

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 | 22 V | 61 % | 37 sec | 0.9 kg/h |
| 3.2 x 350.0 mm | 80-120 A | 25 V | 61 % | 54 sec | 1.3 kg/h |
| 4.0 x 350.0 mm | 80-180 A | 27 V | 61 % | 58 sec | 1.9 kg/h |
| 5.0 x 350.0 mm | 160-210 A | 26 V | 58 % | 70 sec | 2.3 kg/h |