

STAINLESS STEEL

STICK ELECTRODES (SMAW)

Rutile coated stainless electrode especially designed for heat resisting applications. The weld metal has a scaling temperature of about 1150 °C. OK 62.53 is recommended for welding of Avesta 253 MA, steels like AISI 309 and W.Nr 1.4828. The core wire contains Ce.

Specifications	
Classifications	EN ISO 3581-A : E Z 23 10 N R 12
Approvals	CE : EN 13479 UKCA : EN 13479

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

Welding Current	AC, DC+
Ferrite Content	FN 4-8
Alloy Type	CrNi stainless
Coating Type	Rutile

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	550 MPa	730 MPa	35 %

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

Typical Weld Metal Analysis %						
C	Mn	Si	Ni	Cr	N	Ferrite FN
0.07	0.6	1.6	10.4	23.1	0.16	6

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300.0 mm	50-90 A	26 V	55 %	44 sec	0.8 kg/h
3.2 x 350.0 mm	70-110 A	25 V	55 %	66 sec	1.0 kg/h