

OK 63.80

Acid rutile covered MMA-electrode for welding Nb -or Ti-stabilized stainless steels of the CrNiMo 18-12-3 type.

Specifications	
Classifications	EN ISO 3581-A : E 19 12 3 Nb R 3 2 SFA/AWS A5.4 : E318-17 Werkstoffnummer : 1.4576
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 00639

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

Welding Current	DC+, AC
Ferrite Content	FN 6-12
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	507 MPa	614 MPa	38 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	20 °C	55 J
As Welded	-60 °C	41 J

Typical Weld Metal Analysis %								
C	Mn	Si	Ni	Cr	Mo	N	Nb	FN WRC-92
0.02	0.6	0.8	11.5	18.2	2.9	0.08	0.31	7

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.0 x 300.0 mm	45-65 A	29 V	56 %	29 sec	0.8 kg/h
2.5 x 300.0 mm	60-90 A	30 V	56 %	35 sec	1.1 kg/h
3.2 x 350.0 mm	80-120 A	32 V	61 %	54 sec	1.4 kg/h
4.0 x 350.0 mm	120-170 A	33 V	61 %	55 sec	2.1 kg/h