

## OK 63.34

OK 63.34 is a rutile MMA-electrode of the 19Cr 12Ni 3Mo-type designed for vertical down welding of steels of similar composition. It provides beads with a very good finish and good tie in profiles to the joint edges.

### Specifications

<b>Classifications</b>	EN ISO 3581-A : E 19 12 3 L R 1 1 SFA/AWS A5.4 : E316L-16 CSA W48 : E316L-16 Werkstoffnummer : 1.4430
<b>Approvals</b>	CWB : E316L-16 VdTÜV : 03816

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

<b>Welding Current</b>	DC+, AC
<b>Ferrite Content</b>	FN 3-8
<b>Alloy Type</b>	Austenitic CrNiMo
<b>Coating Type</b>	Acid Rutile

### Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS</b>			
As Welded	440 MPa	600 MPa	40 %
<b>ISO</b>			
As Welded	440 MPa	600 MPa	

### Charpy Testing

Testing Condition	Testing Temp	Impact Value
<b>AWS</b>		
As Welded	20 °C	65 J
As Welded	-20 °C	52 J
<b>ISO</b>		
As Welded	20 °C	65 J
As Welded	-120 °C	38 J

### Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.02	0.8	0.8	11.8	18.7	2.8	0.13	6

### Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 300.0 mm	70-90 A	22 V	70 %	39 sec	1.0 kg/h
3.2 x 300.0 mm	80-130 A	25 V	70 %	39 sec	1.6 kg/h