

OK 61.20

Rutile coated electrode for welding 19Cr10Ni -type steels. Also suitable for welding stabilized steels of similar composition, except when the full creep resistance of the base material is to be met. The electrode is especially designed for welding of thin walled pipes. It can be used in all positions including vertical down.

Specifications

Classifications	EN ISO 3581-A : E 19 9 L R 1 1 SFA/AWS A5.4 : E308L-16 Werkstoffnummer : 1.4316
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 10769

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

Welding Current	DC+, AC
Ferrite Content	FN 3 - 10
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	430 MPa	560 MPa	45 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-50 °C	48 J
As Welded	-60 °C	38 J
As Welded	20 °C	70 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Cu	N	FN WRC-92
0.026	0.7	0.7	9.6	19.2	0.05	0.10	5

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	25-60 A	22 V	66 %	38 sec	0.7 kg/h
2.5 x 300.0 mm	28-85 A	22 V	63 %	44 sec	0.9 kg/h