

OK 61.30



Extra-low carbon stainless steel electrode for welding steels of the 19 Cr 10 Ni-type. Also suitable for welding stabilized stainless steels of similar composition when the working temperature is maximum 350°C.

Classifications:	EN ISO 3581-A:E 19 9 L R 1 2, SFA/AWS A5.4:E308L-17, CSA W48:E308L-17, Werkstoffnummer :1.4316
Approvals:	ABS Stainless, CE EN 13479, CWB CSA W48: E308L-17, DB 30.039.02, DNV-GL VL 308 L, NAKS/HAKC 2.0-4.0 mm, Seprož UNA 272580, VdTÜV 00792

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	430 MPa	580 MPa	45 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	20 °C	70 J
As welded	-60 °C	49 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Ferrite FN	N
0.03	0.7	0.9	10.0	19.3	5	0.09

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
1.6 x 300 mm	35-45 A	27 V	0.55 kg	240	24 sec	0.6 kg/h
2.0 x 300 mm	35-65 A	29 V	0.55 kg	160	29 sec	0.8 kg/h
2.5 x 300 mm	50-90 A	31 V	0.55 kg	99	36 sec	1.1 kg/h
3.2 x 350 mm	70-130 A	31 V	0.60 kg	49	54 sec	1.4 kg/h
4.0 x 350 mm	90-180 A	32 V	0.60 kg	33	60 sec	2.0 kg/h
5.0 x 350 mm	140-250 A	33 V	0.60 kg	20	60 sec	3.0 kg/h