

OK 63.30



Extra low carbon stainless steel electrode for welding steels of the 18Cr 12Ni 2.8Mo-type. Also suitable for welding of stabilized stainless steels of similar composition, except when the full creep resistance of the base metal is to be met.

Classifications:	EN ISO 3581-A:E 19 12 3 L R 1 2, SFA/AWS A5.4:E316L-17, Werkstoffnummer :1.4430, CSA W48:E316L-17
Approvals:	CE EN 13479, BV 316L, DNV 316L, Seproz UNA 272580, GL 4571, NAKS/HAKC 2.5-4.0 mm, ABS SFA/AWS A5.4, E316L-17, CWB CSA W48: E316L-17, DB 30.039.06, LR 316L, VdTÜV 00262

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

Welding Current:	DC+, AC
Ferrite Content:	FN 3-10
Alloy Type:	Austenitic CrNiMo

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	460 MPa	570 MPa	40 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As welded	20 °C	60 J
As welded	-20 °C	55 J
As welded	-60 °C	43 J

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.02	0.6	0.8	11.0	18.1	2.6	0.10	6

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 90% I max
1.6 x 300 mm	30-45 A	29 V	0.56	250	37 s	0.4 kg/h
2.0 x 300 mm	45-65 A	29 V	0.60	147	39 s	0.6 kg/h
2.5 x 300 mm	45-90 A	29 V	0.55	96	45 s	0.9 kg/h
3.2 x 350 mm	60-125 A	30 V	0.55	52	57 s	1.4 kg/h
4.0 x 350 mm	70-190 A	32 V	0.56	34	57 s	2.0 kg/h
5.0 x 350 mm	100-280 A	32 V	0.56	21	63 s	3.0 kg/h