OK 61.30

Type Acid-rutile

SMAW
E308L-17

Description

OK 61.30 is an extra-low carbon, AC/DC, LMA electrode for welding steel of the 19Cr10Ni type It is also suitable for welding stabilised stainless steels of similar composition, except when the full creep resistance of the base material is to be met. OK 61.30 is very easy to strike and restrike and produces weld beads with an excellent appearance and self-relieving slag.

Welding current

DC+, AC OCV 50 V

Classifications

EN 1600	E 19 9 L R 1 2
SFA/AWS A5.4	E308L-17
Werkstoff Nr.	1.4316
CSA W48	E 308L-17

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.7	0.9	19.5	10.0	<0.5	<0.5

Typical mech. properties all weld metal

Yield stress, MPa	430
Tensile strength, MPa	560
Elongation A5, %	43

Charpy V

Test temps, °C	Impact values, J
+20	70

Ferrite content FN 3-10

Approvals

ABS	Stainless
CL	EN 1600
CWB	CSA W48
DB	30.039.02
DNV	308L
Sepros	UNA 409820
SS	EN 1600
UDT	EN 1600
VdTÜV	00792
Ü	30.039

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of elec-trodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
1.6	300	35-50	27	0.55	240	0.6	24
2.0	300	45-65	29	0.55	160	0.8	29
2.5	300	60-90	31	0.55	99	1.1	36
3.2	350	80-120	31	0.60	49	1.4	54
4.0	350	120-170	32	0.60	33	2.0	60
5.0	350	150-240	33	0.60	20	3.0	60