

# OK 61.35

Type Basic

SMAW

E308L-15

## Description

OK 61.35 is a basic, low-carbon, stainless electrode of the E308L type with very good welding properties in the vertical and overhead positions. The high impact toughness at cryogenic temperature (-196°C) makes OK 61.35 excellent in LNG applications.

## Welding current

DC+



## Classifications

EN 1600	E 19 9 L B 2 2
SFA/AWS A5.4	E308L-15
Werkstoff Nr.	1.4316

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.04	0.5	1.7	19.0	10.0	<0.3	<0.3

## Typical mech. properties all weld metal

Yield stress, MPa	460
Tensile strength, MPa	580
Elongation A4, %	60

## Charpy V

Test temps, °C	Impact values, J
+20	100
-120	70
-196	>32
Ferrite content	FN 2-7

## Approvals

Sepros	UNA 409820
UDT	EN 1600
VdTÜV	04811

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.5	300	55-85	22	0.61	92	0.9	37
3.2	350	75-110	25	0.61	50	1.3	54
4.0	350	110-155	27	0.61	33	1.9	58
5.0	350	160-210	26	0.51	25	2.2	66