

OK 63.80

Type Acid-rutile

SMAW

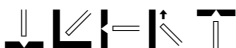
E318-17

Description

OK 63.80 is a stainless LMA electrode for welding Nb- or Ti-stabilised stainless steels of the 18Cr12Ni2-3Mo type. OK 63.80 is specially designed for welding Nb- and Ti-stabilised stainless steel corresponding to DIN Werkstoff Nr: 4573 and 4583.

Welding current

DC+, AC OCV 50 V



Classifications

EN 1600	E 19 12 3 Nb R 3 2
SFA/AWS A5.4	E318-17
Werkstoff Nr.	1.4576

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Nb	Cu
<0.03	0.7	0.9	18.0	12.0	2.8	<0.6	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	500
Tensile strength, MPa	620
Elongation A5, %	35

Charpy V

Test temps, °C	Impact values, J
+20	55

Ferrite content	FN 6-12
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Approvals

SS	EN 1600
UDT	EN 1600
VdTÜV	00639

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
2.0	300	45-65	29	0.56	155	0.8	29
2.5	300	60-90	30	0.56	97	1.1	35
3.2	350	80-120	32	0.61	48	1.4	54
4.0	350	120-170	33	0.61	32	2.1	55