

# OK 61.81

Type Rutile

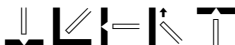
SMAW  
E347-16

## Description

OK 61.81 is a niobium-stabilised, stainless welding electrode for titanium- and niobium-stabilised 18-8 steel. It is particularly suitable for high-temperature applications.

## Welding current

DC+, AC OCV 60 V



## Classifications

EN 1600	E 19 9 Nb R 3 2
SFA/AWS A5.4	E347-16
Werkstoff Nr.	1.4551

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Nb	Cu
0.06	0.7	1.6	20.0	10.0	<0.3	<1.0	<0.3

## Typical mech. properties all weld metal

500°C/10,000h:

Yield stress, MPa	560	
Tensile strength, MPa	700	300
Elongation A4, %	31	

## Charpy V

Test temps, °C	Impact values, J
+20	60

Ferrite content	FN 6-12
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## Approvals

DNV	347
SS	EN 1600
UDT	EN 1600

## 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	40-60	26.2	0.60	147	0.6	39
2.5	300	50-80	28.8	0.59	82	1.2	36
3.2	350	75-115	23	0.60	44	1.2	66
4.0	350	110-160	24	0.60	32	1.7	66
5.0	350	140-210	25	0.60	20	2.3	78