

OK 61.85

Type Basic

SMAW
E347-15

Description

OK 61.85 is a basic coated, niobium stabilised electrode of the E347-type, specially designed for welding niobium- or titanium-stabilised steels. OK 61.85 has outstanding welding properties in the vertical and overhead positions, making it suitable for pipewelding, for example.

Welding current

DC+



Classifications

EN 1600	E 19 9 Nb B 2 2
SFA/AWS A5.4	E347-15
Werkstoff Nr.	1.4551

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Nb	Cu
<0.07	0.5	1.7	19.5	10.0	<0.3	<1.0	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	500
Tensile strength, MPa	620
Elongation A5, %	40

Charpy V

Test temps, °C	Impact values, J
+20	100
-60	70
-120	>32
Ferrite content	FN 6-12

Approvals

Sepros	UNA 409820
UDT	EN 1600
VdTÜV	05663

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	25	0.60	98	0.9	42
3.2	350	75-110	23.3	0.62	49	1.1	64
4.0	350	110-150	23.5	0.61	33	1.6	70
5.0	350	150-200	23.1	0.61	21	2.3	76