

OK 63.35

Type Basic

SMAW

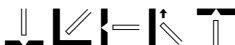
E316L-15

Description

OK 63.35 is a low-carbon, basic, stainless electrode designed for welding steel of the 18Cr12Ni3Mo type. The high impact toughness at cryogenic temperatures (-196°C) makes OK 63.35 excellent in LNG applications. The weld metal is very resistant to cracking and porosity. OK 63.35 has outstanding welding properties in the vertical and overhead positions.

Welding current

DC+



Classifications

EN 1600	E 19 12 3 L B 2 2
SFA/AWS A5.4	E316L-15
Werkstoff Nr.	1.4430

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.04	0.5	1.7	18.5	12.0	2.8	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	430
Tensile strength, MPa	560
Elongation A4, %	40

Charpy V

Test temps, Impact		Test temps, Impact	
°C	values, J	°C	values, J
+20	95	-120	60
-60	75	-196	35

Ferrite content FN 3-8

Approvals

ABS	Stainless
DNV	316L
SS	EN 1600
UDT	EN 1600
VdTÜV	04815

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	24	0.63	91	0.9	42
3.2	350	75-110	24	0.63	47	1.3	58
4.0	350	110-150	24	0.62	32	1.8	63
5.0	350	150-200	24	0.62	20	2.6	68