

OK 64.30

Type Acid-rutile

SMAW

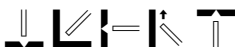
E317L-17

Description

OK 64.30 is an acid-rutile electrode for welding 19Cr 13Ni 3.5Mo (317L) austenitic stainless steels. The high Mo content provides better resistance to acid and pitting corrosion compared with 316L types. OK 64.30 is easy to weld in all positions and yields smooth runs on both AC and DC.

Welding current

DC+, AC OCV 55 V



Classifications

EN 1600	E 19 13 4 N L R 3 2
SFA/AWS A5.4	E317L-17
Werkstoff Nr.	(1.4447)

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.04	0.7	0.9	19.0	13.0	3.8	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	480
Tensile strength, MPa	600
Elongation A5, %	30

Charpy V

Test temps, °C	Impact values, J
+20	45
Ferrite content	FN 5-10

Approvals

UDT	EN 1600
VdTÜV	02311

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	50-80	29	0.56	94	0.8	52
3.2	350	70-120	30	0.56	51	1.4	52
4.0	350	100-170	32	0.56	33	2.1	58