

OK 61.25

Type Basic

SMAW

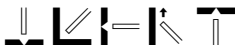
E308H-15

Description

OK 61.25 is a basic coated, stainless-steel electrode of the 308H type. The electrode is designed for high-temperature applications in petrochemical and chemical process plants.

Welding current

DC+



Classifications

EN 1600 E 19 9 H B 2 2
SFA/AWS A5.4 E308H-15

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
0.07	0.5	1.5	19.0	10.0	<0.5	<0.5

Typical mech. properties all weld metal

720°C/1000h:		
Yield stress, MPa	430	300
Tensile strength, MPa	600	570
Elongation A4, %	45	45

Charpy V

Test temps, °C	Impact values, J	
+20	96	100

Ferrite content FN 2-5100

Approvals

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
2.5	300	55-85	23	0.62	93	0.9	47
3.2	350	75-110	23	0.59	49	1.2	66
4.0	350	100-155	24	0.61	32	1.8	68