

# OK 61.50

Type Acid-rutile

SMAW  
E308H-17

## Description

OK 61.50 is a stainless-steel electrode for welding non-stabilised 18Cr 10Ni austenitic steels for elevated temperatures.

## Welding current

DC+, AC OCV 55 V



## Classifications

EN 1600 E 19 9 H R 1 2  
SFA/AWS A5.4 E308H-17

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
0.06	0.7	0.9	20.0	10.0	<0.5	<0.3

## Typical mech. properties all weld metal

Yield stress, MPa 430  
Tensile strength, MPa 600  
Elongation A4, % 45

## Charpy V

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

Ferrite content FN 3-10

## 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	50-85	27	0.56	98	0.9	42
3.2	350	70-110	27	0.56	51	1.1	63
4.0	350	110-165	28	0.56	34	1.7	62