

OK 64.30



An extra low carbon AC/DC stainless electrode of the 19/12/3 type

Classification AWS A 5.4: E 317L-16
IS 5206: E 19 12 3 LR 26
DIN 8556: E 18 13 4 LR 23



DESCRIPTION

OK 64.30 is an extra low carbon AC/DC stainless steel electrode of the type 19Cr, 13Ni, 3.5 Mo with controlled ferrite content of 4 to 8 for maximum resistance to inter-crystalline corrosion, stress corrosion cracking, hot cracking and chemical corrosion. The weldmetal display excellent resistance to creep and the higher molybdenum reduce the weldmetal susceptibility to pitting. OK 64.30, has excellent weldability in all positions, a slag cover that is self peeling and a weld bead appearance which is smooth and shiny. The welds are of radiographic quality.

WELDING CURRENT: DC +, AC

TYPICAL APPLICATIONS

OK 64.30 is designed for welding stainless steel corresponding to AISI 317, 317L, DIN W Nr: 4438, British Standard: 317 S 12, Swedish Standard: SS-steel 2367. The electrode finds extensive use where severe corrosion takes place involving sulphuric acid and sulphurous acids and their salts. OK 64.30 is also for steel fabrications in, which post weld heat treatment is to be avoided.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.028	Cr	19.0	YS	450 N/mm ²
Mo	3.7	S	0.015	UTS	600 N/mm ²
Si	0.7	P	0.020	EL (L=4d)	35%
Ni	13			Impact (CVN) at +20°C	55J
Mn	0.8			Ferrite	4-8 FN

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	60-90	80	400
3.25	350	85-130	60	300
4.00	350	120-180	40	200
5.00	350	160-240	25	125

PACKING: Electrodes are packed in heat sealed plastic cartons and five of these cartons are shrink wrapped in a cardboard box.