

OK 61.30



A rutile coated extra low carbon AC/DC stainless steel electrode of the 19/9 type

Classification AWS A5.4: E 308L-16
 IS 5206: E 19.9 LR 26



DESCRIPTION

OK 61.30 is a rutile based extra low carbon 19/10 type stainless steel electrode with a controlled ferrite of 3-8 FN, that provides excellent resistance to corrosion, cracking and high temperature scaling resistance upto 800°C. The enormous welder appeal that OK 61.30 enjoys is due to excellent weldability in all positions, easy striking and restriking, stable and quite arc, a slag cover that is self-peeling and a final bead appearance that is finely rippled and shiny. In most cases OK 61.30 gives acceptable results on niobium or titanium stabilised austenitic stainless steels with the carbon content low enough to eliminates the possibility of inter-crystalline cracking

APPROVALS : PDIL,NPC

WELDING CURRENT: DC+, AC 50 V

TYPICAL APPLICATIONS

OK 61.30 is especially designed for welding austenitic stainless steels corresponding to AISI 304L, 304, 308L, 308, Werkstoff Nr: 4306, 4301, 4541, Swedish steels SS 2352, 2333 having a very low carbon content, BS: En 58, 58A, 58E grades. Widely used in industries like food and beverage, chemicals, etc.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.025	P	0.020	UTS	570 N/mm ²
Mn	0.90	Si	0.70	YS	390 N/mm ²
Cr	19.50	S	0.015	EL (L=4d)	42%
Ni	10.00			Ferrite	3-8 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
3.15	350	80-120	60	300
4.00	350	120-170	40	200
5.00	350	150-240	25	125

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