

OK 61.50



A low carbon 19/9 stainless steel electrode

Classification AWS A5.4: E 308-16
 IS5206: E 19.9 R26



DESCRIPTION

OK 61.50 is an AC/DC rutile coated stainless steel electrode with unique low moisture absorption coating which deposits low carbon 19Cr 10Ni type metal. The unique flux coating allows easy striking and restriking and is completely free from short-circuiting during welding. The arc is stable, very smooth, with negligible spatter level, and gives welds with a self-releasing slag cover that is finely rippled and shiny.

APPROVALS: PDIL, RDSO

WELDING CURRENT: DC±, AC 65V

TYPICAL APPLICATIONS

OK 61.50 finds extensive use in fabrication of austenitic stainless steels of 18.8 type corresponding to AISI types 301, 304 & 308, German Steel nos. 4016, 4501, 4300, 4301, Continental Steels V2A, Sandvik OR-2, UHB stainless 33 etc. It also finds use in building up Stainless Steel surfaces on centrifugal pumps, impellers, shafts, valve seats, chemical plants and certain grades of armour steels that are difficult to weld other wise.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.06	Si	0.70	YS	440 N/mm ²
Mn	0.80	S	0.015	UTS	600 N/mm ²
Cr	19.00	P	0.020	EL (L=4d)	40%
Ni	10.00			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
3.15	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. Also available in ready to use vacuum pack cartons.