

# OK 63.80



## A rutile based Nb bearing 19/12/3 stainless steel electrode

Classification      AWS A5.4: E 318-16  
IS 5206: E 19.12.2 Nb R 26  
DIN 8556: E 19 123 Nb R 23



### DESCRIPTION

OK 63.80 is a rutile based, low carbon 19/12/3 type stainless steel electrode, stabilised with Niobium to resist intergranular corrosion between 425°C and 845°C. The electrode deposits a weldmetal that has a controlled ferrite content of 5-9 FN for maximum resistance to cracking, corrosion and scaling. The weldmetal has good creep strength and is of radiographic quality. OK 63.80 electrodes possess outstanding arc and current carrying characteristics in all positions with a slag that is self peeling and a bead that is finely rippled and shiny.

**WELDING CURRENT:** DC+, AC 50 V

### TYPICAL APPLICATIONS

OK 63.80 is especially designed for the welding of Ti and Nb stabilised stainless steels with similar base composition corresponding to AISI 316 and 318 types. It is widely used in chemical plants handling corrosive acids like sulphuric acid, hydrochloric acid, tartaric acid, acetic acid, formic acid, citric acid etc., in paper and pulp industries using paper mill equipment, bleaching equipment, textile industries using equipment for dyeing and bleaching, heat resistant castings etc.

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.06	Ni	12.5	UTS	620 N/mm <sup>2</sup>
Mn	0.90	Si	0.60	YS	430 N/mm <sup>2</sup>
Cr	19.0	P	0.020	EL (L=4d)	30%
Nb	0.70	S	0.015	Ferrite	5-9 FN
Mo	2.8				

### 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

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