OK 61.30

OK 61.30 is a very low-carbon stainless steel LMA electrode for welding alternating current (AC/DC) or direct current (DC) type 19Cr10Ni and stabilised stainless steels of similar composition, except where the resistance to penetration specified for the base material must be achieved. Welding with OK 61.30 is very easy, the welds are excellent and the gel can be removed easily.

Technical data	
Classifications	EN ISO 3581-A: E 19 9 L R 1 2 SFA/AWS A5.4 : E308L-17 CSA W48 : E308L-17 Werkstoffnummer : 1.4316
Approvals	ABS : Stainless CE : EN 13479 CWB : E308L-17 DB : 30.039.02 DNV-GL : VL 308 L UKCA : EN 13479 VdTÜV : 00792

Approvals are based on factory location. Please contact ESAB for more information.

Welding speed	DC+, AC
Ferrite content	FN 3-10
Type of alloy	Austenitic CrNi
Type of lagging	Acid Rutile
Min AC OCV	50

Typical mechanical characteristics			
Conditions	**Yield stress**	**Tensile strength**	**Relevant explanation**
ISO			
After welding	430 MPa	580 MPa	45 %

Udarno Charpy V		
Conditions	**Test temperature**	**Udarno KV**
ISO		
After welding	20 °C	70 J
After welding	-60 °C	49 J

Typical chemical composition of an alloy %						
C	**Mn**	**Si**	**Ni**	**Cr**	**N**	**FN WRC-92**
0.03	0.7	0.9	10.0	19.3	0.09	5

Alloy performance data					
diameter	**A**	**V**	**Performance (%)**	**Electrode burning time**	**Alloying capacity at 90% I max.**
1.6 x 300 mm	35-45 A	27 V	55 %	24 sec	0.6 kg/h
2.0 x 300 mm	35-65 A	29 V	55 %	29 sec	0.8 kg/h
2.5 x 300 mm	50-90 A	31 V	55 %	36 sec	1.1 kg/h
3.2 x 350 mm	70-130 A	31 V	60 %	54 sec	1.4 kg/h
4.0 x 350 mm	90-180 A	32 V	60 %	60 sec	2.0 kg/h
5.0 x 350 mm	140-250 A	33 V	60 %	60 sec	3.0 kg/h