

OK 61.30



Extra low carbon stainless steel electrode for welding steels of the 19 Cr 10 Ni-type.

Also suitable for welding stabilized stainless steels of similar composition, except when the full creep resistance of the base material is to be met.

| | |
|------------------------|---|
| Classifications | SFA/AWS A5.4 : E308L-17 EN ISO 3581-A : E 19 9 L R 1 2 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 NAKS/HAKC 2.0-4.0 mm Seproz UNA 272580 VdTUV 00792 |

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

| | |
|------------------------|-----------------|
| Welding Current | DC+, AC |
| Ferrite Content | FN 3-10 |
| Alloy Type | Austenitic CrNi |
| Coating Type | Acid Rutile |

Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|------------|----------------|------------------|------------|
| ISO | | | |
| As Welded | 430 MPa | 580 MPa | 45 % |

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|------------|---------------------|--------------|
| ISO | | |
| As Welded | 20 °C | 70 J |
| As Welded | -60 °C | 49 J |

Typical Weld Metal Analysis %

| C | Mn | Si | Ni | Cr | N | Ferrite FN |
|------|-----|-----|------|------|------|------------|
| 0.03 | 0.7 | 0.9 | 10.0 | 19.3 | 0.09 | 5 |

Deposition Data

| Diameter | Current | Voltage | Number of electrodes/ kg weld metal | Fusion time per electrode at 90% I max | Deposition Efficiency % | Deposition Rate @ 90% I max |
|----------------|-----------|---------|--|--|----------------------------|--------------------------------|
| 1.6 x 300.0 mm | 35-45 A | 27 V | 240 | 24 sec | 55 % | 0.6 kg/h |
| 2.0 x 300.0 mm | 35-65 A | 29 V | 160 | 29 sec | 55 % | 0.8 kg/h |
| 2.5 x 300.0 mm | 50-90 A | 31 V | 99 | 36 sec | 55 % | 1.1 kg/h |
| 3.2 x 350.0 mm | 70-130 A | 31 V | 49 | 54 sec | 60 % | 1.4 kg/h |
| 4.0 x 350.0 mm | 90-180 A | 32 V | 33 | 60 sec | 60 % | 2.0 kg/h |
| 5.0 x 350.0 mm | 140-250 A | 33 V | 20 | 60 sec | 60 % | 3.0 kg/h |