

# OK 63.30



Extra low carbon stainless steel electrode for welding steels of the 18Cr 12Ni 2.8Mo-type.

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

<b>Classifications</b>	SFA/AWS A5.4 : E316L-17 EN ISO 3581-A : E 19 12 3 L R 1 2 CSA W48 : E316L-17 Werkstoffnummer : 1.4430
<b>Approvals</b>	ABS E316L-17 BV 316L CE EN 13479 CWB E316L-17 DB 30.039.06 DNV-GL VL 316 L LR 316L NAKS/HAKC 2.5-4.0 mm Seproz UNA 272580 VdTUV 00262

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

<b>Welding Current</b>	DC+, AC
<b>Ferrite Content</b>	FN 3-10
<b>Alloy Type</b>	Austenitic CrNiMo
<b>Coating Type</b>	Acid Rutile

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	460 MPa	570 MPa	40 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As Welded	20 °C	60 J
As Welded	-20 °C	55 J
As Welded	-60 °C	43 J

## Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.02	0.6	0.8	11.0	18.1	2.6	0.10	6

## 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	30-45 A	29 V	250	37 sec	56 %	0.4 kg/h
2.0 x 300.0 mm	45-65 A	29 V	147	39 sec	60 %	0.6 kg/h
2.5 x 300.0 mm	45-90 A	29 V	96	45 sec	55 %	0.9 kg/h
3.2 x 350.0 mm	60-125 A	30 V	52	57 sec	55 %	1.4 kg/h
4.0 x 350.0 mm	70-190 A	32 V	34	57 sec	56 %	2.0 kg/h
5.0 x 350.0 mm	100-280 A	32 V	21	63 sec	56 %	3.0 kg/h