OK 63.30

A rutile based extra low carbon 19/9/2 stainless steel electrode

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Classification AWS A5.4: E 316L-16
IS 5206: E 19.12.2L R 26
DIN 8556: E 19.12.3 R 23

DESCRIPTION

OK 63.30 is an extra low carbon, rutile electrode with a unique low moisture absorption coating depositing a weldmetal of the type 18% Cr, 13% Ni, 2.8% Mo with a controlled ferrite number of 3-8 FN. The weldability of OK 63.30 is outstanding in all positions with both AC and DC current. It is completely free from short-circuiting during welding coupled with excellent striking and restriking properties, a self-lifting slag and a final weld appearance that is extremely smooth and shiny.

APPROVALS : PDIL, NPC

WELDING CURRENT: DC+, AC 50 V

TYPICAL APPLICATIONS

OK 63.30 is especially designed for the welding of 18/13/Mo type steels corresponding to AISI 316 and 316L, 317 type stainless steels. Commonly used in chemical tanks paper mill equipment, bleaching equipment, chemicals plants, textile plants, where vessel surfaces are exposed to severe corrosion by sulphuric, sulphurous, hydrochloric, acetic, phosphoric, citric, tartaric acids etc. and also for components exposed to high temperatures for e.g. heat resistant castings. It is also suitable for welding titanium and niobium stabilised 18-12 steels of the type SS 2344 & 2345 except when the corrosive conditions are severe.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.025	Mo	2.8	UTS	580 N/mm^2
Mn	0.90	Ni	12.5	YS	390 N/mm^2
Cr	19.0	Si	0.70	EL (L=4d)	40%
S	0.015	P	0.020	Ferrite	3-8 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.