

## OK 61.63



OK 61.63 is a rutile based low carbon 20Cr-10Ni type stainless steel electrode with controlled ferrite that provides excellent resistance to corrosion, cracking and high temperature scaling up to 800°C.

<b>Classifications</b>	SFA/AWS A5.4 : E308L-16
<b>Approvals</b>	PDIL E308L-16

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

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

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS</b>			
As Welded	470 MPa	610 MPa	42 %

### Current Range

Diameter	Current	Deposition Rate @ 90% I max
2.5 x 350.0 mm	60-90 A	0.0 kg/h
3.15 x 350.0 mm	80-120 A	0.0 kg/h
4.0 x 350.0 mm	120-170 A	0.0 kg/h
5.0 x 350.0 mm	160-210 A	0.0 kg/h