

# OK 63.50

## A low carbon 19/12/2 stainless steel electrode



Classification    AWS A5.4: E 316-16  
IS 5206: E 19.12.2 R 26  
DIN 8556: E 19 123 R 23

### DESCRIPTION

OK 63.50 is a 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 63.50 is outstanding like any other ESAB stainless steel electrode with excellent striking and restriking properties, a self peeling slag and a weld that is extremely smooth and shiny. Its extreme ease of operation in all positions with exceedingly low spatter and stable arc makes it a favourite of welders.

**APPROVALS :** NPC, PDIL

**WELDING CURRENT:** DC+, AC 50 V

### TYPICAL APPLICATIONS

OK 63.50 is especially designed for the welding of 18/13/Mo type steels corresponding to AISI 316 and 317 type stainless steels. Commonly used in chemical tanks, coils and vats that are exposed to severe corrosion by sulphuric, sulphurous, hydrochloric, acetic, phosphoric, citric, tartaric acids that are found in paper and pulp industries, textile industries, chemical mixers, paint and dye industries.

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.06	Mo	2.5	UTS	600 N/mm <sup>2</sup>
Mn	0.80	Ni	12.5	YS	420 N/mm <sup>2</sup>
Cr	19.5	Si	0.60	EL (L=4d)	38%
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. Vacuum packed cartons are also available on demand.