

OK 63.20



Rutile coated electrode for welding 18Cr12Ni3Mo -type steels. Also suitable for welding stabilized steels of similar composition. The electrode is especially designed for welding of thin walled pipes. Diameters 1.6 - 2.5mm. It can be used in all positions including vertical down.

Classifications	SFA/AWS A5.4 : E316L-16 EN ISO 3581-A : E 19 12 3 L R 1 1 CSA W48 : E316L-16 Werkstoffnummer : 1.4430
Approvals	CE EN 13479 CWB CSA W48: E316L-16 NAKS/HAKE 2.5-3.2 mm Sepro UN 272580 VdTUV 09716

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

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	480 MPa	590 MPa	41 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C	56 J
As Welded	-60 °C	46 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.02	0.7	0.7	12.1	18.4	2.8	0.11	4

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	15-40 A	23 V	227	53 sec	63 %	0.3 kg/h
2.0 x 265.0 mm	18-60 A	22 V	167	44 sec	65 %	0.6 kg/h
2.0 x 300.0 mm	18-60 A	25 V	152	49 sec	62 %	0.5 kg/h
2.5 x 300.0 mm	25-80 A	22 V	96	54 sec	63 %	0.8 kg/h
3.2 x 350.0 mm	55-110 A	26 V	52	65 sec	60 %	1.2 kg/h