# OK 61.30


Extra-low carbon stainless steel electrode for welding steels of the 19 Cr 10 Ni-type. Also suitable for welding stabilized stainless steels of similar composition, except when full creep resistance of the base material is to be met.

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|---|---|
| **Classifications:** | EN ISO 3581-A:E 19 9 L R 1 2, SFA/AWS A5.4:E308L-17, Werkstoffnummer :1.4316, CSA W48:E308L-17 |
| **Approvals:** | CE EN 13479, Seproz UNA 272580, ABS Stainless, CWB CSA W48: E308L-17, DB 30.039.02, DNV 308L, NAKS/HAKC 2.0-4.0 mm, VdTÜV 00792 |

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

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|---|---|
| **Welding Current:** | DC+, AC |
| **Ferrite Content:** | FN 3-10 |
| **Alloy Type:** | Austenitic CrNi |
| **Coating Type:** | Acid Rutile |

## Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|---|---|---|---|
| **ISO** | | | |
| As welded | 430 MPa | 580 MPa | 45 % |

## Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|---|---|---|
| **ISO** | | |
| As welded | 20 °C | 70 J |
| As welded | -60 °C | 49 J |

## Typical Weld Metal Analysis %

| C | Mn | Si | Ni | Cr | N | Ferrite FN |
|---|---|---|---|---|---|---|
| 0.03 | 0.7 | 0.9 | 10.0 | 19.3 | 0.09 | 5 |

## Deposition Data

| Diameter | Current | Voltage | kg weld metal/ kg electrodes | Number of electrodes/kg weld metal | Fusion time per electrode at 90% I max | Deposition rate 90% I max |
|---|---|---|---|---|---|---|
| 1.6 x 300 mm | 35-45 A | 27 V | 0.55 | 240 | 24 s | 0.6 kg/h |
| 2.0 x 300 mm | 35-65 A | 29 V | 0.55 | 160 | 29 s | 0.8 kg/h |
| 2.5 x 300 mm | 50-90 A | 31 V | 0.55 | 99 | 36 s | 1.1 kg/h |
| 3.2 x 350 mm | 70-130 A | 31 V | 0.60 | 49 | 54 s | 1.4 kg/h |
| 4.0 x 350 mm | 90-180 A | 32 V | 0.60 | 33 | 60 s | 2.0 kg/h |
| 5.0 x 350 mm | 140-250 A | 33 V | 0.60 | 20 | 60 s | 3.0 kg/h |