

OK 61.81



Nb-stabilized MMA-electrode for welding Nb- or Ti-stabilized stainless steel of the 19Cr10Ni-type. OK 61.81 has a better hot cracking resistance compared with OK 61.80. Owing to the quite high ferrite content level, the working temperature should be limited to maximum 400°C.

Classifications:	EN ISO 3581-A:E 19 9 Nb R 3 2, SFA/AWS A5.4:E347-16, Werkstoffnummer :1.4551
Approvals:	CE EN 13479, DNV 347, NAKS/HAKC 3.2 mm

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

Welding Current:	DC+, AC
Ferrite Content:	FN 6-12
Alloy Type:	Austenitic CrNi
Coating Type:	Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As welded	560 MPa	700 MPa	31 %
Creep resistance+ 500°C 20000h	-	310 MPa	-
Creep resistance 600°C 10000h	-	135 MPa	-
Creep resistance++ 500°C 10000h	-	330 MPa	-
ISO			
As welded	550 MPa	700 MPa	-

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As welded	20 °C	60 J
ISO		
As welded	-10 °C	71 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	N	Nb	Ferrite FN
0.06	1.7	0.7	9.7	20.2	0.08	0.72	7