

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 when the working temperature is maximum 350°C.

Classifications	SFA/AWS A5.4 : E308L-17 EN ISO 3581-A : E 19 9 L R 1 2 CSA W48 : E308L-17 Werkstoffnummer : 1.4316
Approvals	ABS Stainless CE EN 13479 CWB CSA W48: E308L-17 DB 30.039.02 DNV-GL VL 308 L NAKS/HAKC 2.0-4.0 mm Sepro UN A 272580 VdTUV 00792

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

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	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	35-45 A	27 V	240	24 sec	55 %	0.6 kg/h
2.0 x 300.0 mm	35-65 A	29 V	160	29 sec	55 %	0.8 kg/h
2.5 x 300.0 mm	50-90 A	31 V	99	36 sec	55 %	1.1 kg/h
3.2 x 350.0 mm	70-130 A	31 V	49	54 sec	60 %	1.4 kg/h
4.0 x 350.0 mm	90-180 A	32 V	33	60 sec	60 %	2.0 kg/h
5.0 x 350.0 mm	140-250 A	33 V	20	60 sec	60 %	3.0 kg/h