



Product Data Sheet

E 'Manual metal-arc welding'

OK 64.30

Prepared by A-C Thorsson	Qualified by P-O Oskarsson	Approved by Tapio Huhtala	Reg no EN007566	Cancelling EN007110	Reg date 2017-06-19	Page 1 (2)
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REASON FOR ISSUE

General description amended. Impact toughness values revised, typical RT value changed and new values added for -20°C.

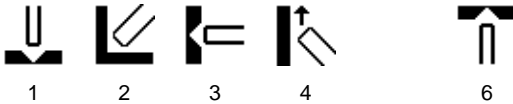
GENERAL

OK 64.30 is a low carbon rutile covered electrode for welding of 19Cr 13Ni 3-4Mo- type stainless steel. The higher molybdenum content provides a higher pitting corrosion resistance than E316L types.

Min AC OCV: 55
Polarity: DC+, AC

Alloy Type: Austenitic CrNiMo
Coating Type: Acid Rutile
Ferrite Content: FN 5-10

WELDING POSITIONS



CLASSIFICATIONS Electrode

EN ISO 3581-A E Z 19 13 4 N L R 3 2
SFA/AWS A5.4 E317L-17
Werkstoffnummer (1.4447)

APPROVALS

Sepro UNA 272580
VdTÜV 02311

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max	Nom
C		0.040	
Si	0.50	1.00	
Mn	0.50	1.20	
P		0.025	
S		0.020	
Cr	18.0	20.0	
Ni	12.0	14.0	
Mo	3.5	4.0	
Cu		0.3	
N		0.15	
Ferrite FN			8



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MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO		AWS	
	Min	Typ	Min	Typ
Rp0.2 (MPa)	350	480	350	480
Rm (MPa)	550	600	550	600
A4 (%)			30	35
A5 (%)	25	30		
Z (%)			40	45
Charpy V at 20°C (J)	40	49		
Charpy V at -20°C (J)	32	46		

Comments:

Interpass temperature max. 150 °C.

Hardness weld metal HV 190 - 220.

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 300	50	80	1.9	103	0.56	94	0.8	52	29	1,2,3,4,6
3.2 x 350	60	120	3.5	103	0.56	51	1.4	52	30	1,2,3,4,6
4.0 x 350	80	170	5.4	104	0.56	33	2.1	58	32	1,2,3,4,6

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)

OTHER DATA

Hardness data:

Weld metal, as welded condition, matching base material, V-Joint, no buttering, transverse cross section: 197 - 238 HV10

Redrying: 350 °C, 2h.