

OK 63.35



A low carbon basic coated stainless steel electrode of the 19/12/2 type.



Classification AWS A 5.4: E 316L-15
IS 5206: E 19.12.2 B 20
DIN 8556: E 19.12.3 LB

DESCRIPTION

OK 63.35 is a low carbon basic covered stainless steel electrode of the 19% Cr, 12% Ni, 2.8% Mo type. It is highly resistant to cracking and porosity, and has excellent welding properties in the vertical and overhead positions.

WELDING CURRENT: DC +

TYPICAL APPLICATIONS

OK 63.35 is mainly used for welding stainless steels having a corresponding analysis, but can also be used for welding certain air hardening steels, e.g. armour plate, and for butt welding stainless steel to unalloyed or low alloyed carbon steels. Its welding properties are particularly remarkable during vertical welding. OK 63.35 is intended for welding acid resisting austenitic steels corresponding to AISI 316 and similar steels.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.025	Ni	12.0	UTS	550 N/mm ²
Mn	1.7	Cr	18.5	YS	400 N/mm ²
Si	0.5	Mo	2.8	EL (L=4d)	40%
S	0.018	P	0.020	Ferrite	3-8 FN

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	55-85	80	400
3.15	350	75-110	65	325
4.00	350	110-155	40	200
5.00	350	150-210	30	150

PACKING: Electrodes are packed in heat sealed plastic cartons and five of these cartons are shrink wrapped in a cardboard box.