

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.

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 SeproZ UNA 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

Yield Strength	Tensile Strength	Elongation
430 MPa (62.3 ksi)	580 MPa (84.1 ksi)	45 %

Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
20 °C (68 °F)	70 J (52 ft-lb)
-60 °C (-76 °F)	49 J (36 ft-lb)

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
1.6 x 300 mm (1/16 x 12 in.)	35-45 A	27 V	0.55	240	24 sec	0.6 kg/h (1.3 lb/h)
2.0 x 300 mm (5/64 x 12 in.)	35-65 A	29 V	0.55	160	29 sec	0.8 kg/h (1.8 lb/h)
2.5 x 300 mm (3/32 x 12 in.)	50-90 A	31 V	0.55	99	36 sec	1.1 kg/h (2.4 lb/h)
3.2 x 350 mm (1/8 x 14 in.)	70-130 A	31 V	0.60	49	54 sec	1.4 kg/h (3.1 lb/h)
4.0 x 350 mm (5/32 x 14 in.)	90-180 A	32 V	0.60	33	60 sec	2.0 kg/h (4.4 lb/h)
5.0 x 350 mm (3/16 x 14 in.)	140-250 A	33 V	0.60	20	60 sec	3.0 kg/h (6.6 lb/h)