Product Data Sheet

E 'Manual metal-arc welding'

OK 62.53

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
A-C Thorsson	Tero Borg	Tapio Huhtala	EN007104	EN005990	2016-02-23	1 (2)

REASON FOR ISSUE

Ferrite FN added under Chemical Composition. Hardness data added under Other Data.

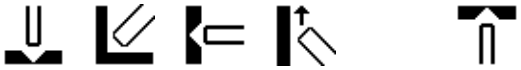
GENERAL

Rutile coated stainless electrode especially designed for heat- resisting applications.The weld metal has a scaling temperature of about 1150 °C. OK 62.53 is recommended for welding of Avesta 253 MA, steels like AISI 309 and W.Nr 1.4828.

Min AC OCV: 65
Polarity: AC, DC+

Alloy Type: CrNi stainless
Coating Type: Rutile
Ferrite Content: FN 8-12

WELDING POSITIONS



1 2 3 4 6

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max	Nom
C	0.06	0.08	
Si	1.40	1.80	
Mn	0.50	0.90	
P		0.030	
S		0.020	
Cr	22.0	24.0	
Ni	10.0	11.0	
Mo		0.5	
Cu		0.20	
N	0.15	0.20	
Ferrite FN			8

MECHANICAL PROPERTIES OF WELD METAL

	ISO	
	As welded	
Properties	**Min**	**Typ**
Rp0.2 (MPa)	520	550
Rm (MPa)	680	730
A5 (%)	30	35
Charpy V at 20°C (J)	47	60

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ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U	Welding
Ø x Length	Min	Max								Positions
2.5 x 300	50	90	1.7	96	0.55	104	0.8	44	26	1,2,3,4,6
3.2 x 350	70	110	3.4	97	0.55	54	1.0	66	25	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:

As welded condition, all weld metal, transverse cross section of an ISO joint, measurements done along a horizontal (5 indents) - and vertical line (10 indents), 2 samples tested, 219 - 270 HV10, average 249 HV10.

Redrying 300 °C, 2h.