



Product Data Sheet

E 'Manual metal-arc welding'

OK 63.34

Prepared by A-C Thorsson	Qualified by Tero Borg	Approved by Tapio Huhtala	Reg no EN007106	Cancelling EN006112	Reg date 2016-02-24	Page 1 (2)
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REASON FOR ISSUE

Product description amended. N and Ferrite FN added under Chemical Composition.

GENERAL

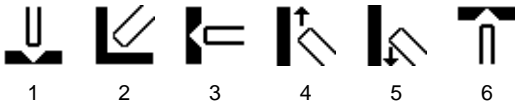
OK 63.34 is a rutile MMA-electrode of the 19Cr 12Ni 3Mo-type designed for vertical down welding of steels of similar composition.

It provides beads with a very good finish and good tie in profiles to the joint edges.

Min AC OCV: 60
Polarity: DC+, AC

Alloy Type: Austenitic CrNiMo
Coating Type: Acid Rutile
Ferrite Content: FN 3-8

WELDING POSITIONS



CLASSIFICATIONS Electrode

EN ISO 3581-A E 19 12 3 L R 1 1
SFA/AWS A5.4 E316L-16
CSA W48 E316L-16
Werkstoffnummer 1.4430

APPROVALS

CWB E316L-16
Seproz UNA 272580
VdTÜV 03816

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max	Nom
C		0.030	
Si	0.50	1.00	
Mn	0.50	1.20	
P		0.025	
S		0.020	
Cr	17.0	19.0	
Ni	11.0	13.0	
Mo	2.5	3.0	
Cu		0.3	
N		0.15	
Ferrite FN			6



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MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO		AWS	
	Min	Typ	Min	Typ
Rp0.2 (MPa)	360	440	360	440
Rm (MPa)	510	600	510	600
A4 (%)			30	40
A5 (%)	27			
Z (%)		50	40	50
Charpy V at 20°C (J)	40	65		65
Charpy V at -20°C (J)				52
Charpy V at -120°C (J)	32	38		

Comments:

Interpass temperature max. 150 °C.
Hardness weld metal HV 180 - 220.

ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 300	70	90	5.1	100	0.70	94	1.0	39	22	1,2,3,4,5,6
3.2 x 300	80	130	4.2	100	0.70	59	1.6	39	25	1,2,3,4,5,6

- 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

Redrying: 350 °C, 2h.