

OK 63.34



OK 63.34 is a stainless electrode of the 19Cr12Ni2.8Mo type, designed for the vertical-down welding of steels of similar composition. OK 63.34 produces beads with a very good finish and a smooth transition to the joint edges. The slag volume is fairly small and is easy to manipulate and easy to remove.

Classifications	SFA/AWS A5.4 : E316L-16 EN ISO 3581-A : E 19 12 3 L R 1 1 CSA W48 : E316L-16 Werkstoffnummer : 1.4430
Approvals	CWB E316L-16 Sepro UN A 272580 VdTUV 03816

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+, AC
Ferrite Content	FN 3-8
Alloy Type	Austenitic CrNiMo
Coating Type	Acid Rutile

Typical Tensile Properties

Yield Strength	Tensile Strength	Elongation
ISO		
AWS		

Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
AWS	
20 °C (68 °F)	65 J (48 ft-lb)
-20 °C (-4 °F)	52 J (38 ft-lb)
ISO	
20 °C (68 °F)	65 J (48 ft-lb)
-120 °C (-184 °F)	38 J (28 ft-lb)

Deposition Data

Diameter	Current	Voltage	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Burn-off Time/Electrode	Deposition Rate
2.5 x 300.0 mm (0.098 x 11.8 in.)	70-90 A	22 V	-	94	39 sec	-
3.2 x 300.0 mm (1/8 x 11.8 in.)	80-130 A	25 V	-	59	39 sec	-