OK 61.25

OK 61.25 is a basic coated, stainless-steel electrode of the 308H type. The electrode is designed for high-temperature applications in petrochemical and chemical process plants.

Classifications	SFA/AWS A5.4 : E308H-15 EN ISO 3581-A : E 19 9 H B 2 2
Approvals	NAKS/HAKC 2.5-4.0 mm Seproz UNA 272580

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

Welding Current	DC+
Ferrite Content	FN 2-5
Alloy Type	Austenitic CrNi
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
PWHT 1000hr 720°C (1328°F)	300 MPa (44 ksi)	570 MPa (83 ksi)	45 %
As Welded	430 MPa (62 ksi)	600 MPa (87 ksi)	45 %

Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
AWS	
20 °C (68 °F)	95 J (70 ft-lb)
-18 °C (0 °F)	83 J (61 ft-lb)
-40 °C (-40 °F)	67 J (50 ft-lb)
20 °C (68 °F)	100 J (74 ft-lb)

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Burn-off Time/ Electrode	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 300.0 mm (0.098 x 11.8 in.)	55-85 A	23 V	93	47 sec	62 %	0.9 kg/h (2.0 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	75-110 A	23 V	49	66 sec	59 %	1.2 kg/h (2.6 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	80-160 A	24 V	32	68 sec	61 %	1.8 kg/h (4.0 lb/h)

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