



OK 63.30

SOLICITE UMA COTAÇÃO DESTE PRODUTO.

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Typical Tensile Properties

As welded

| Elongation | Gás de protecção | Tensile Strength | Yield Strength |
|------------|------------------|------------------|----------------|
| 40 % | ISO | 570 MPa | 460 MPa |
| - | AWS | - | - |

Propriedades do Teste Charpy com Entalhe em V

As welded

| Gás de protecção | Impact Value | Testing Temperature |
|------------------|--------------|---------------------|
| ISO | 60 J | 20 °C |
| ISO | 55 J | -20 °C |
| ISO | 43 J | -60 °C |

Análise de Metal de Soldadura

| Mn | Mo | C | Si | Ferrite FN | Ni | N | Cr |
|-------|-------|--------|-------|------------|--------|--------|--------|
| 0.6 % | 2.6 % | 0.02 % | 0.8 % | 6 % | 11.0 % | 0.10 % | 18.1 % |

Valores de depósito

| Amps | Diâmetro | Fusion time per electrode at 90% I max | kg weld metal/kg electrodes | Number of electrodes/kg weld metal | Taxa de Deposição | Volts |
|-----------|--------------|--|-----------------------------|------------------------------------|-------------------|-------|
| 30-45 A | 1.6 x 300 mm | 37 sec | 0.56 kg | 250 | 0.4 kg/h | 29 V |
| 45-65 A | 2.0 x 300 mm | 39 sec | 0.60 kg | 147 | 0.6 kg/h | 29 V |
| 45-90 A | 2.5 x 300 mm | 45 sec | 0.55 kg | 96 | 0.9 kg/h | 29 V |
| 60-125 A | 3.2 x 350 mm | 57 sec | 0.55 kg | 52 | 1.4 kg/h | 30 V |
| 70-190 A | 4.0 x 350 mm | 57 sec | 0.56 kg | 34 | 2.0 kg/h | 32 V |
| 100-280 A | 5.0 x 350 mm | 63 sec | 0.56 kg | 21 | 3.0 kg/h | 32 V |

| | |
|------------------------|---|
| Aprovações: | ABS, SFA/AWS A5:4, E316L-17, BV, 316L, CE, EN 13479, CWB, CSA W48: E316L-17, DB, 30.039.06, DNV-GL, VL 316 L, LR, 316L, NAKS/HAKC, 2.5-4.0 mm, Seproz, UNA 272580, VdTÜV, 00262 |
| Classificações: | EN ISO 3581-A, E 19 12 3 L R 1 2, SFA/AWS A5.4, E316L-17, CSA W48, E316L-17, Werkstoffnummer, 1.4430 |

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

| | |
|-------------------------|-------------------|
| Alloy Type: | Austenitic CrNiMo |
| Ferrite Content: | FN 3-10 |
| Welding Current: | DC+, AC |

