OK 53.16 SPEZIAL

OK 53.16 is a double coated electrode combining the running characteristics of a rutile with the mechanical properties of a basic electrode. The double coating enables it to be used with small transfomers with low OCV. OK 53.16 welds on both AC and DC.

Specifications	
Classifications	SFA/AWS A5.1 : E7016 EN ISO 2560-A : E 38 2B 32 H10
Approvals	ABS : 3Y BV : 3,3Y H10 CE : EN 13479 DB : 10.039.29 DNV : 3YH10 GL : 3YH10 LR : 3YH10 VdTÜV : 02762

Welding Current	AC, DC+-
Diffusible Hydrogen	< 10.0 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	450 MPa	530 MPa	28 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
As Welded	-20 °C	90 J

Typical Weld Metal Analysis %		
C	**Mn**	**Si**
0.07	0.9	0.6

Deposition Data						
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Number of electrodes/kg weld metal**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
2.5 x 350.0 mm	50-90 A	26,8 V	58 %	83,3	59 sec	0.73 kg/h
3.2 x 350.0 mm	90-150 A	31,2 V	54 %	53,6	56 sec	1.2 kg/h
3.2 x 450.0 mm	90-150 A	30,3 V	57 %	39,5	72 sec	1.27 kg/h
4.0 x 450.0 mm	120-190 A	28 V	59 %	24	90 sec	1.65 kg/h
5.0 x 450.0 mm	160-230 A	28 V	61 %	15.5	109 sec	2.14 kg/h

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