

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 transformers 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 : 3Y H10 CE : EN 13479 DB : 10.039.29 DNV : 3 YH10 LR : 3Y H15 UKCA : EN 13479 VdTÜV : 02762

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

Welding Current	AC, DC+-
Diffusible Hydrogen	< 10.0 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering
Min AC OCV	50 V

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	450 MPa	530 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	-20 °C	90 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.07	1.0	0.6

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm	50-90 A	27 V	58 %	59 sec	0.73 kg/h
3.2 x 350 mm	90-150 A	31 V	54 %	56 sec	1.2 kg/h
3.2 x 450 mm	90-150 A	30 V	57 %	72 sec	1.27 kg/h
4.0 x 450 mm	120-190 A	28 V	59 %	90 sec	1.65 kg/h
5.0 x 450 mm	160-230 A	28 V	61 %	109 sec	2.14 kg/h