OK 53.16 Spezial

OK 53.16 is a double-coated electrode combining the running characteristics of a rutile electrode with the mechanical properties of a basic electrode. OK 53.16 welds on both AC and DC and the spatter loss is minimal.

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

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	0.9	0.6

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 350 mm	50-90 A	26,8 V	0,58	83,3	59 s	0.73 kg/h
3.2 x 350 mm	90-150 A	31,2 V	0,54	53,6	56 s	1,2 kg/h
3.2 x 450 mm	90-150 A	30,3 V	0,57	39,5	72 s	1,27 kg/h
4.0 x 450 mm	120-190 A	28 V	0.59	24	90 s	1.65 kg/h
5.0 x 450 mm	160-230 A	28 V	0.61	15.5	109 s	2.14 kg/h