

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:	ABS 3Y, BV 3,3Y H10, CE EN 13479, DB 10.039.29, DNV 3YH10, GL 3YH10, 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:	Carbon Manganese
Coating Type:	Basic covering

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
2.5 x 350 mm	50-90 A	26,8 V	0,58 kg	83,3	59 sec	0.73 kg/h
3.2 x 350 mm	90-150 A	31,2 V	0,54 kg	53,6	56 sec	1,2 kg/h
3.2 x 450 mm	90-150 A	30,3 V	0,57 kg	39,5	72 sec	1,27 kg/h
4.0 x 450 mm	120-190 A	28 V	0,59 kg	24	90 sec	1.65 kg/h
5.0 x 450 mm	160-230 A	28 V	0,61 kg	15.5	109 sec	2.14 kg/h