

# 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.

<b>Classifications:</b>	SFA/AWS A5.1:E7016, EN ISO 2560-A:E 38 2B 32 H10
<b>Approvals:</b>	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.

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