

## 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.

<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

<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
<b>ISO</b>			
As Welded	450 MPa	530 MPa	28 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As Welded	-20 °C	90 J

### Typical Weld Metal Analysis %

C	Mn	Si
0.07	0.9	0.6

### Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
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