OK 67.60



Acid-rutile coated MMA-electrode giving an overalloyed weld metal. Suitable for welding stainless steel to mild and low alloyed steels. Also suitable for welding of transition layers when surfacing mild steel with stainless steel weld metal.

Specifications	
Classifications	EN ISO 3581-A : E 23 12 L R 3 2 SFA/AWS A5.4 : E309L-17 CSA W48 : E309L-17 Werkstoffnummer : 1.4332
Approvals	CE : EN 13479 CWB : E309L-17 DNV : NV 309 UKCA : EN 13479 VdTÜV : 00898

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

Welding Current	DC+, AC
Ferrite Content	FN 10-22
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile
Min AC OCV	55

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	470 MPa	580 MPa	32 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
As Welded	20 °C	50 J
As Welded	-10 °C	40 J

Typical Weld Metal Analysis %						
C	**Mn**	**Si**	**Ni**	**Cr**	**N**	**FN WRC-92**
0.03	0.9	0.8	12.4	23.7	0.09	15

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
2.0 x 300 mm	45-65 A	27 V	60 %	38 sec	0.7 kg/h
2.5 x 300 mm	45-90 A	28 V	60 %	38 sec	1.1 kg/h
3.2 x 350 mm	65-120 A	29 V	60 %	51 sec	1.6 kg/h
4.0 x 350 mm	85-180 A	31 V	60 %	51 sec	2.5 kg/h
5.0 x 350 mm	110-250 A	32 V	60 %	58 sec	3.3 kg/h