OK 67.70



Acid rutile MMA-electrode giving an over alloyed weld metal. Suitable for welding acid resistant stainless steels to mild and low alloyed steels. Also suitable for welding buffer layers when surfacing mild steel with acid resistant stainless steel weld metal.

Specifications	
Classifications	EN ISO 3581-A : E 23 12 2 L R 3 2 SFA/AWS A5.4 : E309LMo-17 CSA W48 : E309LMo-17 Werkstoffnummer : 1.4459
Approvals	ABS : SS to C- &CMn steels BV : 309Mo CE : EN 13479 CWB : E309LMo-17 DB : 30.039.05 DNV : NV 309 Mo LR : SS/CMn RINA : 309MO UKCA : EN 13479 VdTÜV : 02424

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

Welding Current	DC+, AC
Ferrite Content	FN 12-22
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile
Min AC OCV	55

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	510 MPa	610 MPa	32 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
As Welded	20 °C	50 J
As Welded	-20 °C	35 J

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**N**	**FN WRC-92**
0.02	0.6	0.8	13.4	22.5	2.8	0.09	18

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
2.0 x 300 mm	40-60 A	26 V	58 %	48 sec	0.6 kg/h
2.5 x 300 mm	50-90 A	29 V	57 %	45 sec	0.9 kg/h
3.2 x 350 mm	60-120 A	27 V	59 %	61 sec	1.4 kg/h
4.0 x 350 mm	85-180 A	31 V	61 %	56 sec	2.0 kg/h

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Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
5.0 x 350 mm	110-250 A	30 V	59 %	64 sec	2.7 kg/h