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-GL : VL 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

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	510 MPa (74 ksi)	610 MPa (88 ksi)	32 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	20 °C (68 °F)	50 J (37 ft-lb)
As Welded	-20 °C (-4 °F)	35 J (26 ft-lb)

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	**Current**	**Voltage**	**Deposition Efficiency (%)**	**Burn-off Time /Electrode**	**Deposition Rate @ 90% I max**
2.0 x 300 mm (5/64 x 11.8 in.)	40-60 A	26 V	58 %	48 sec	0.6 kg/h (1.3 lbs/h)
2.5 x 300 mm (0.098 x 11.8 in.)	50-90 A	29 V	57 %	45 sec	0.9 kg/h (2.0 lbs/h)
3.2 x 350 mm (1/8 x 13.8 in.)	60-120 A	27 V	59 %	61 sec	1.4 kg/h (3.1 lbs/h)

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Deposition Data					
Diameter	**Current**	**Voltage**	**Deposition Efficiency (%)**	**Burn-off Time /Electrode**	**Deposition Rate @ 90% I max**
4.0 x 350 mm (5/32 x 13.8 in.)	85-180 A	31 V	61 %	56 sec	2.0 kg/h (4.4 lbs/h)
5.0 x 350 mm (0.197 x 13.8 in.)	110-250 A	30 V	59 %	64 sec	2.7 kg/h (6.0 lbs/h)