

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.

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 CSA W48: E309L-17, DNV-GL VL 309, NAKS/HAKC 2.5-4.0 mm, Seproz UNA 272580, 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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As welded			
ISO			
As welded	470 MPa	580 MPa	32 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	20 °C	50 J
As welded	-10 °C	40 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Ferrite FN	N
0.03	0.9	0.8	12.4	23.7	15	0.09

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
2.0 x 300 mm	45-65 A	27 V	0.60 kg	136	38 sec	0.7 kg/h
2.5 x 300 mm	45-90 A	28 V	0.60 kg	85	38 sec	1.1 kg/h
3.2 x 350 mm	65-120 A	29 V	0.60 kg	45	51 sec	1.6 kg/h
4.0 x 350 mm	85-180 A	31 V	0.60 kg	29	51 sec	2.5 kg/h
5.0 x 350 mm	110-250 A	32 V	0.60 kg	19	58 sec	3.3 kg/h