

# 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.

<b>Classifications:</b>	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
<b>Approvals:</b>	CE EN 13479, Seproz UNA 272580, ABS SS to C&C/Mn steels, BV 309Mo, CWB CSA W48: E309LMo-17, DB 30.039.05, DNV 309 Mo, LR SS/CMn, RINA 309Mo, VdTUV 02424

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

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	510 MPa (74 ksi)	610 MPa (88.5 ksi)	32 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	50 J (37 ft-lb)
As Welded	-20 °C (-4 °F)	> 32 J (24 ft-lb)

## Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.02	0.6	0.8	13.4	22.5	2.8	0.09	18

## Deposition Data

Diameter	Current	Voltage	Efficiency (%)
2 mm (5/64 in.)	40-60 A	26 V	120 %
2.5 mm (3/32 in.)	50-90 A	29 V	120 %
3.2 mm (1/8 in.)	60-120 A	27 V	120 %
4 mm (5/32 in.)	85-180 A	31 V	120 %
5 mm (3/16 in.)	110-250 A	30 V	120 %