

# 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.

<b>Welding Current:</b>	DC+, AC
<b>Ferrite Content:</b>	FN 12-22
<b>Alloy Type:</b>	Austenitic CrNi
<b>Coating Type:</b>	Acid Rutile

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As welded	510 MPa	610 MPa	32 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As welded	20 °C	50 J
As welded	-20 °C	35 J

## 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	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.0 x 300 mm	40-60 A	26 V	0.58	147	48 s	0.6 kg/h
2.5 x 300 mm	50-90 A	29 V	0.57	94	45 s	0.9 kg/h
3.2 x 350 mm	60-120 A	27 V	0.59	47	61 s	1.4 kg/h
4.0 x 350 mm	85-180 A	31 V	0.61	32	56 s	2.0 kg/h
5.0 x 350 mm	110-250 A	30 V	0.59	20	64 s	2.7 kg/h