

## 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>	ABS : SS to C&C/Mn steels BV : 309Mo CE : EN 13479 CWB : E309LMo-17 DB : 30.039.05 DNV-GL : VL 309 Mo LR : SS/CMn NAKS/HAKC : 3.2 mm RINA : 309Mo Seproz : UNA 272580 VdTÜV : 02424

<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	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.0 x 300.0 mm	40-60 A	26 V	58 %	147	48 sec	0.6 kg/h
2.5 x 300.0 mm	50-90 A	29 V	57 %	94	45 sec	0.9 kg/h
3.2 x 350.0 mm	60-120 A	27 V	59 %	47	61 sec	1.4 kg/h
4.0 x 350.0 mm	85-180 A	31 V	61 %	32	56 sec	2.0 kg/h
5.0 x 350.0 mm	110-250 A	30 V	59 %	20	64 sec	2.7 kg/h