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	SFA/AWS A5.4 : E309L-17 EN ISO 3581-A : E 23 12 L R 3 2 CSA W48 : E309L-17 Werkstoffnummer : 1.4332
Approvals	CE EN 13479 CWB 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
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	N	Ferrite FN
0.03	0.9	0.8	12.4	23.7	0.09	15

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
2.0 x 300.0 mm	45-65 A	27 V	136	38 sec	60 %	0.7 kg/h
2.5 x 300.0 mm	45-90 A	28 V	85	38 sec	60 %	1.1 kg/h
3.2 x 350.0 mm	65-120 A	29 V	45	51 sec	60 %	1.6 kg/h
4.0 x 350.0 mm	85-180 A	31 V	29	51 sec	60 %	2.5 kg/h
5.0 x 350.0 mm	110-250 A	32 V	19	58 sec	60 %	3.3 kg/h

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