

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 : E309L-17 DNV-GL : VL 309 NAKS/HAKC : 2.5-4.0 mm Seproz : UNA 272580 VdTÜV : 00898

Welding Current	DC+, AC
Ferrite Content	FN 10-22
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	470 MPa	580 MPa	32 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-10 °C	40 J
As Welded	20 °C	50 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	Amps	Volts	Efficiency (Per)	Number of electrodes/kg weld metal	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.0 x 300.0 mm	45-65 A	27 V	60 %	136	38 sec	0.7 kg/h
2.5 x 300.0 mm	45-90 A	28 V	60 %	85	38 sec	1.1 kg/h
3.2 x 350.0 mm	65-120 A	29 V	60 %	45	51 sec	1.6 kg/h
4.0 x 350.0 mm	85-180 A	31 V	60 %	29	51 sec	2.5 kg/h
5.0 x 350.0 mm	110-250 A	32 V	60 %	19	58 sec	3.3 kg/h