

OK 67.70

Type Acid-rutile

SMAW

E309MoL-17

Description

OK 67.70 is an over-alloyed, stainless-steel electrode for use as a buffer layer in welding acid-resistant clad steels and stainless steels to other types of steel. OK 67.70 has outstanding welding properties on both AC and DC. The electrode can be used in all positions except vertical down.

Welding current

DC+, AC OCV 55 V



Classifications

EN 1600	E 23 12 2 L R 3 2
SFA/AWS A5.4	E309MoL-17
Werkstoff Nr.	1.4459
CSA W48	E309LMO-17

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.7	0.9	23.0	13.0	2.8	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	510
Tensile strength, MPa	610
Elongation A5, %	32

Charpy V

Test temps, °C	Impact values, J
+20	50
-20	> 32

Ferrite content	FN 12-22
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Approvals

ABS	SS to C&C/Mn steels	RINA	E 309Mo
CL	EN 1600	Sepros	UNA
CWB	CSA W48	SS	EN 1600
DB	30.039.05	UDT	EN 1600
DNV	309 Mo	VdTÜV	02424
LR	SS/CMn	Ü	30.039

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.0	300	30-60	26	0.58	147	0.6	48
2.5	300	50-90	29	0.57	94	0.9	45
3.2	350	90-120	27	0.59	47	1.4	61
4.0	350	130-180	31	0.61	32	2.0	56
5.0	350	160-240	30	0.59	20	2.7	64
5.0	450	160-240	30	0.57	15	2.7	85