

# 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>	SFA/AWS A5.4 : E309LMo-17 EN ISO 3581-A : E 23 12 2 L R 3 2 CSA W48 : E309LMo-17 Werkstoffnummer : 1.4459
<b>Approvals</b>	ABS SS to C&C/Mn steels BV 309Mo CE EN 13479 CWB CSA W48: E309LMo-17 DB 30.039.05 DNV-GL VL 309 Mo LR SS/CMn NAKS/HAKC 3.2 mm RINA 309Mo Sepro UN A 272580 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 (74 ksi)	610 MPa (88 ksi)	32 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As Welded	20 °C (68 °F)	50 J (37 ft-lb)
As Welded	-20 °C (-4 °F)	35 J (26 ft-lb)

## 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	Number of electrodes/ kg weld metal	Burn-off Time/ Electrode	Deposition Efficiency %	Deposition Rate @ 90% I max
2.0 x 300.0 mm (5/64 x 11.8 in.)	40-60 A	26 V	147	48 sec	58 %	0.6 kg/h (1.3 lb/h)
2.5 x 300.0 mm (0.098 x 11.8 in.)	50-90 A	29 V	94	45 sec	57 %	0.9 kg/h (2.0 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	60-120 A	27 V	47	61 sec	59 %	1.4 kg/h (3.1 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	85-180 A	31 V	32	56 sec	61 %	2.0 kg/h (4.4 lb/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	110-250 A	30 V	20	64 sec	59 %	2.7 kg/h (6.0 lb/h)