OK 67.70

OK 67.70 is a rutile based, over alloyed stainless steel electrode giving a weld deposit of 23Cr-13Ni-2.5Mo type, for welding stainless steels to other types of steels and for use as a buffer layer in welding acid resisting clad steels.

Specifications	
Classifications	SFA/AWS A5.4 : E309Mo-16
Approvals	PDIL : E309Mo-16

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+
Ferrite Content	15-24 FN
Alloy Type	Austenitic Cr-Ni-Mo
Coating Type	Rutile

Typical Tensile Properties				
Condition	**Conditional Statement**	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS				
As Welded	As welded	520 MPa	650 MPa	32 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	20 °C	50 J
As Welded	-20 °C	35 J

Typical Weld Metal Analysis %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**
0.06	0.60	0.80	13.50	24.00	2.60

Deposition Data	
Diameter	**Current**
2.5 x 350 mm	60-100 A
3.15 x 350 mm	80-120 A
4.0 x 350 mm	120-170 A