

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 %					
С	Mn	Si	Ni	Cr	Мо
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	