

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.

Specifications	
Classifications	CSA W48 : E309L-17 EN 1600 : E 23 12 L R 3 2 SFA/AWS A5.4 : E309L-17 Werkstoff Nr. : 1.4332
Approvals	CE EN 13479 CWB CSA W48 GL 4332 Sepros UNA 272580 VdTÜV 00898

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

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

Typical Tensile Properties			
Conditional Statement	Yield Strength	Tensile Strength	Elongation
As welded	470 MPa (68.2 ksi)	580 MPa (84.1 ksi)	32 %

Typical Charpy V-Notch Properties	
Testing Temperature	Impact Value
20 °C (68 °F)	50 J (67 ft-lb)
-10 °C (14 °F)	40 J (29.5 ft-lb)

Deposition Data						
Diameter	Current	Voltage	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Burn-off Time /Electrode	Deposition Rate
2.0 x 300 mm (5/64 x 12 in.)	45-65 A	27 V	0.60	136	38 sec	0.7 kg/h (1.5 lbs/h)
2.5 x 300 mm (3/32 x 12 in.)	45-90 A	28 V	0.60	85	38 sec	1.1 kg/h (2.4 lbs/h)
3.2 x 350 mm (1/8 x 14 in.)	65-120 A	29 V	0.60	45	51 sec	1.6 kg/h (3.5 lbs/h)
4.0 x 350 mm (5/32 x 14 in.)	85-180 A	31 V	0.60	29	51 sec	2.5 kg/h (5.5 lbs/h)
5.0 x 350 mm (3/16 x 14 in.)	110-250 A	32 V	0.60	19	58 sec	3.3 kg/h (7.2 lbs/h)