

OK 67.71

Overalloyed high efficiency stainless steel electrode for welding transition layers when surfacing mild steel with stainless, joining stainless steel to other types of steel.

Specifications	
Classifications	EN ISO 3581-A : E 23 12 2 L R 5 3 SFA/AWS A5.4 : E309LMo-26 Werkstoffnummer : 1.4459
Approvals	DNV-GL : VL 309 Mo VdTÜV : 02484

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

Welding Current	DC+, AC
Ferrite Content	FN 12-22
Alloy Type	Austenitic CrNiMo
Coating Type	Acid Rutile

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	500 MPa	620 MPa	35 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	-60 °C	30 J
As Welded	20 °C	55 J

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.04	0.9	0.9	13.3	22.9	2.6	0.08	15

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 350.0 mm	60-130 A	34 V	61 %	47 sec	2.2 kg/h
4.0 x 450.0 mm	110-170 A	36 V	61 %	71 sec	3.0 kg/h
5.0 x 450.0 mm	170-230 A	40 V	63 %	79 sec	4.3 kg/h