

## 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

|                        |                                                                                                              |
|------------------------|--------------------------------------------------------------------------------------------------------------|
| <b>Classifications</b> | EN ISO 3581-A : E 23 12 L R 3 2<br>SFA/AWS A5.4 : E309L-17<br>CSA W48 : E309L-17<br>Werkstoffnummer : 1.4332 |
| <b>Approvals</b>       | CE : EN 13479<br>CWB : E309L-17<br>DNV-GL : VL 309<br>UKCA : EN 13479<br>VdTÜV : 00898                       |

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

|                        |                 |
|------------------------|-----------------|
| <b>Welding Current</b> | DC+, AC         |
| <b>Ferrite Content</b> | FN 10-22        |
| <b>Alloy Type</b>      | Austenitic CrNi |
| <b>Coating Type</b>    | Acid Rutile     |

### Tensile Properties

| Testing Condition | Yield Strength | Tensile Strength | Elongation |
|-------------------|----------------|------------------|------------|
| <b>ISO</b>        |                |                  |            |
| As Welded         | 470 MPa        | 580 MPa          | 32 %       |

### Charpy Testing

| Testing Condition | Testing Temp | Impact Value |
|-------------------|--------------|--------------|
| <b>ISO</b>        |              |              |
| As Welded         | -10 °C       | 40 J         |
| As Welded         | 20 °C        | 50 J         |

### Typical Weld Metal Analysis %

| C    | Mn  | Si  | Ni   | Cr   | N    | FN WRC-92 |
|------|-----|-----|------|------|------|-----------|
| 0.03 | 0.9 | 0.8 | 12.4 | 23.7 | 0.09 | 15        |

### Deposition Data

| Diameter       | Amps      | Volts | Efficiency (Per) | Fusion time per electrode at 90Per I max | Deposition rate at 90Per |
|----------------|-----------|-------|------------------|------------------------------------------|--------------------------|
| 2.0 x 300.0 mm | 45-65 A   | 27 V  | 60 %             | 38 sec                                   | 0.7 kg/h                 |
| 2.5 x 300.0 mm | 45-90 A   | 28 V  | 60 %             | 38 sec                                   | 1.1 kg/h                 |
| 3.2 x 350.0 mm | 65-120 A  | 29 V  | 60 %             | 51 sec                                   | 1.6 kg/h                 |
| 4.0 x 350.0 mm | 85-180 A  | 31 V  | 60 %             | 51 sec                                   | 2.5 kg/h                 |
| 5.0 x 350.0 mm | 110-250 A | 32 V  | 60 %             | 58 sec                                   | 3.3 kg/h                 |