

# 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.

<b>Classifications</b>	SFA/AWS A5.4 : E309L-17 EN ISO 3581-A : E 23 12 L R 3 2 CSA W48 : E309L-17 Werkstoffnummer : 1.4332
<b>Approvals</b>	CE EN 13479 CWB E309L-17 DNV-GL VL 309 NAKS/HAKC 2,5-4,0 mm Seproz UNA 272580 VdTUV 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

## Typical Tensile Properties

Yield Strength	Tensile Strength	Elongation
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	Fusion time per electrode at 90% I max	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 lb/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 lb/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 lb/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 lb/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 lb/h)