



OK 67.70

SMAW

OK 67.70 is an over-alloyed, stainless steel electrode for use as a buffer layer when welding acid-resistant clad steels and stainless steels to other types of steel. OK 67.70 has outstanding welding properties on both AC and DC. The electrode can be used in all positions apart from vertical down.

Welding Current

DC+, AC OCV 55V



PACKING/ORDERING INFORMATION				
Part Number	Dia (mm)	Inner Carton (kg)	Carton Weight (kg)	Pallet Weight (kg)
6770202030	2.0	1.7	10.2	785.4
6770252030	2.5	1.7	10.2	785.4
6770323020	3.2	4.3	12.9	851.4
6770403020	4.0	4.4	13.2	871.2

CLASSIFICATIONS	APPROVALS	TYPICAL ALL WELD METAL COMPOSITION (%)	TYPICAL MECH. PROPERTIES ALL WELD METAL
<u>SFA/AWS A5.4</u>	ABS SS to C&C/Mn steels	C <0.03	<u>Yield Stress, Mpa</u>
E309MoL-17	CE EN 13479	Si 0.7	510
<u>EN 1600</u>	CWB CSA W48	Mn 0.9	<u>Tensile Strength, Mpa</u>
E 23 12 2 L R 3 2	DB 30.039.05	Cr 23.0	610
<u>Werkstoff Nr.</u>	DNV 309 Mo	Ni 13.0	<u>Elongation, %</u>
1.4459	LR SS/CMn	Mo 2.8	32
<u>CSA W48</u>	RINA E 309Mo	Cu <0.3	<u>Charpy V</u>
E309LMO-17	Sepros UNA 409820		Test Temps, °C Impact Values, J
	VdTUV 02424	Ferrite Content FN 12-22	+20 50
	BV 309Mo		-20 35

WELDING PARAMETERS							
Diameter (mm)	Length (mm)	Welding Current, A	Arc Voltage, V	N. Kg Weld Metal/(kg) Electrodes	B. No. Of Electrodes/(kg) Weld Metal	H. Kg Weld Metal/(hour) Arc Time	T. Burn-off time, (secs)/ Electrode
2.0	300	30-60	26	0.58	147	0.6	48
2.5	300	50-90	29	0.57	94	0.9	45
3.2	350	90-120	27	0.59	47	1.4	61
4.0	350	130-180	31	0.61	32	2.0	56
5.0	350	160-240	30	0.59	20	2.7	64
5.0	450	160-240	30	0.57	15	2.7	85

