

OK 67.60

Type Acid-rutile

SMAW

E309L-17

Description

OK 67.60 is an over-alloyed stainless electrode for welding stainless to mild steel and low-alloy steel, for surfacing mild steel and for welding the root runs in clad steel. The electrode has excellent weldability in all positions except vertical down, on both AC and DC.

Welding current

DC+, AC OCV 55 V



Classifications

EN 1600	E 23 12 L R 3 2
SFA/AWS A5.4	E309L-17
Werkstoff Nr.	1.4332
CSA W48	E309L-17

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.7	0.9	24.0	13.0	<0.3	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	470
Tensile strength, MPa	580
Elongation A5, %	32

Charpy V

Test temps, °C	Impact values, J
+20	50
-10	40

Ferrite content FN 12-22

Approvals

CL	EN 1600
CWB	CSA W48
Sepros	UNA 409820
UDT	DIN 1600
VdTÜV	00898

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, s/ electrode
2.0	300	30-60	27	0.60	136	0.7	38
2.5	300	50-90	28	0.60	85	1.1	38
3.2	350	90-120	29	0.60	45	1.6	51
4.0	350	130-180	31	0.60	29	2.5	51
4.0	450	130-180	31	0.60	23	2.5	65
5.0	350	160-240	32	0.60	19	3.3	58