

OK 67.70



A rutile based, 23 Cr, 12 Ni, 2 Mo type stainless steel electrode



Classification AWS A 5.4: E 309Mo-16
IS 5206: E 23.12.2 R 26
DIN 8556: E 23 12 3L R 23

DESCRIPTION

OK 67.70 is rutile based, medium-heavy coated, “over-alloyed” stainless steel electrode for giving a 25 Cr, 12 Ni, 2.5 Mo deposit for use as a buffer layer in welding acid resisting clad steels and stainless steels to other types of steels. The addition of molybdenum to the 25 Cr, 12 Ni deposit improves tensile strength and corrosion resistance. The weldmetal possess excellent resistance to chemical corrosion and heat. OK 67.70 welds with a very smooth and quite arc which is stable in all positions and a slag system that allows a very easily removable slag and very finely rippled, smooth and shiny weld bead. The weldmetal is of radiographic quality.

APPROVALS : PDIL, NPC

WELDING CURRENT: DC +, AC 50V

TYPICAL APPLICATIONS

OK 67.70 is especially designed for welding of acid resisting clad steels and stainless steels to other types of steels for e.g. welding of the root runs in the transition between the stainless layer in a clad steel and the unalloyed base material. OK 67.70 is also widely used for joining of dissimilar metals such as molybdenum bearing austenitic stainless steels to carbon steel, for welding of 309 Mo types steels, and also for surfacing and building up on carbon steels.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.08	Mo	2.5	UTS	650 N/mm ²
Mn	0.80	Si	0.70	YS	450 N/mm ²
Cr	23.0	S	0.018	EL (L=4d)	35%
Ni	12.5	P	0.020		

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	60-90	80	400
3.15	350	80-120	60	300
4.00	350	120-170	40	200
5.00	350	150-240	25	125

PACKING: Electrodes are packed in heat sealed plastic cartons and five of these cartons are shrink wrapped in a cardboard box.