



# Product Data Sheet

E 'Manual metal-arc welding'

OK 67.71

Prepared by A-C Thorsson	Qualified by Tero Borg	Approved by Tapio Huhtala	Reg no EN007239	Cancelling EN007122	Reg date 2016-05-12	Page 1 (2)
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## REASON FOR ISSUE

Approvals revised. DNV amended to DNV-GL. Hardness information provided under Mechanical Properties removed.

## GENERAL

Overalloyed high efficiency stainless steel electrode for welding transition layers when surfacing mild steel with stainless, joining stainless steel to other types of steel.

**Min AC OCV:** 65  
**Polarity:** DC+, AC

**Alloy Type:** Austenitic CrNiMo  
**Coating Type:** Acid Rutile  
**Ferrite Content:** FN 12-22

## WELDING POSITIONS



## CLASSIFICATIONS Electrode

EN ISO 3581-A E 23 12 2 L R 5 3  
SFA/AWS A5.4 E309LMo-26  
Werkstoffnummer 1.4459

## APPROVALS

DNV-GL VL 309 Mo  
VdTÜV 02484

## CHEMICAL COMPOSITION

### All Weld Metal (%)

	Min	Max	Nom
C		0.04	
Si	0.50	1.00	
Mn	0.50	1.20	
P		0.025	
S		0.020	
Cr	22.0	24.0	
Ni	12.0	14.0	
Mo	2.50	3.00	
Cu		0.20	
N		0.15	
Ferrite FN			15



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## MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO		AWS
	Min	Typ	Min
Rp0.2 (MPa)	400	500	400
Rm (MPa)	560	620	560
A4 (%)			30
A5 (%)	30	35	
Z (%)		50	40
Charpy V at 20°C (J)	40	55	40
Charpy V at -60°C (J)		30	

### Comments:

Interpass temp. < 150 °C.

## ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
3.2 x 350	60	130	4.8	150	0.61	35	2.2	47	34	1,2,3
4.0 x 450	110	170	9.3	150	0.61	18	3.0	71	36	1,2,3
5.0 x 450	170	230	14.5	150	0.63	11	4.3	79	40	1,2,3

- W** = Weight (kg / 100 electrodes)  
**η** = Efficiency (g weld metal x 100 / g core wire)  
**N** = Effective value (kg weld metal / kg electrodes)  
**B** = Changes (number of electrodes / kg weld metal)  
**H** = Deposit rate at 90% of max current (kg weld metal / hour arc time)  
**T** = Fusion time at 90% of max current (s / electrode)  
**U** = Arc voltage (V)

## OTHER DATA

Hardness data:

weld metal, dissimilar V-joint between the base materials 1.4573 and StE 36, thickness 20mm, welded in PF position, transverse cross section, measurements done along a vertical line (6 indents): 207 - 240 HV10, average: 222 HV10

Redrying: 350 °C, 2h.