

# OK 73.08

Type Lime-basic

SMAW

E8018-G

## Description

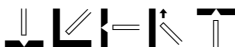
OK 73.08 is a NiCu-alloyed LMA electrode, which deposits a weld metal with good corrosion resistance to sea-water and flue gases, for the welding of weatherproof steel and for ship's hull structural steel. The weld metal has excellent mechanical properties. It is particularly suitable for welding the shell plating of ice-breakers and other ships, which work under conditions where the protective paint coating wears off.

## Recovery

125%

## Welding current

AC, DC(+) OCV 65 V



## Classifications

SFA/AWS A5.5	E8018-G
EN 499	E 46 5 Z B 32
ISO 2560	E 51 5 B 120 26 H

## Typical all weld metal composition, %

C	Si	Mn	Ni	Cu
0.06	0.4	1.0	0.7	0.4

## Typical mech. properties all weld metal

Yield stress, MPa	500
Tensile strength, MPa	590
Elongation, %	27

## Charpy V

Test temps, °C	Impact values, J
-20	160
-40	130
-50	70

## Approvals

ABS	3H5, 3Y
BV	3Y HH
DB	10.039.20
DNV	3 YH10
DS	EN 499
GL	3YH15
LR	3, 3Y H15
RS	3YHH
Sepros	UNA 485154
SFS	EN 499
SS	EN 499
UDT	EN 499
Ü	10.039/1
VdTÜV	02115

## 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	60-90	20	0.62	113.0	0.7	42
2.5	350	80-115	21	0.62	66.0	0.9	59
3.2	350	100-150	23	0.62	43	1.2	68
3.2	450	100-150	22	0.66	30.5	1.3	90
4.0	450	130-200	23	0.68	20.0	1.8	100
5.0	450	190-280	27	0.70	13.5	2.6	106
6.0	450	240-370	28	0.68	9.5	3.3	115