

OK 73.68

Type Lime-basic

SMAW

E8018-C1

Description

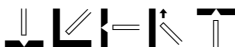
OK 73.68 is a 2.5% nickel-alloyed LMA electrode suitable for the welding of low-alloy steels with impact requirements down to -60°C. The composition of the weld metal is such that good, low-temperature impact properties are obtained, even when welding vertically up. The weld metal of OK 73.68 is also noted for its good corrosion resistance to sea-water and sulphuric acid fumes.

Recovery

120%

Welding current

AC, DC+ OCV 65 V



Classifications

SFA/AWS A5.5 E8018-C1
EN 499 E 46 6 2Ni B 32 H5

Typical all weld metal composition, %

C	Si	Mn	Ni
0.05	0.3	1.0	2.4

Typical mech. properties all weld metal

Yield stress, MPa 520
Tensile strength, MPa 610
Elongation, % 26

Charpy V

Test temps, °C Impact values, J
-55 110
-59 105
-60 105

Approvals

ABS 3H5, 3Y400
BV UP
CL EN 499
DNV 5 YH10
GL 6Y55H10
LR 5Y40H15
PRS 4YH10
RS 3YHH
Sepros UNA 485154
SFS EN 499
UDT EN 499
VdTÜV 01529

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	55-75	21	0.62	130.0	0.6	46
2.5	350	70-110	23	0.62	70.0	0.9	55
3.2	450	105-150	23	0.62	32.0	1.4	81
4.0	450	140-190	23	0.65	21.0	2.0	88
5.0	450	190-270	27	0.65	13.5	2.5	104