

OK 74.78

Type Lime basic

SMAW

E9018-D1

Description

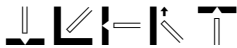
OK 74.78 is an LMA electrode suitable for welding high tensile steels used in low-temperature applications. Good notch toughness down to -40°C. Very suitable for both the enclosed welding and cladding of rails, when a hardness of about 250 HV is required. The moisture content of the coating is very low, which makes OK 74.78 suitable when preheating cannot be applied.

Recovery

125%

Welding current

AC, DC+ OCV 70 V



Classifications

SFA/AWS A5.5 E9018-D1
EN 757 E 55 4 MnMo B 120 20BH

Typical all weld metal composition, %

C	Si	Mn	Mo
0.06	0.4	1.5	0.4

Typical mech. properties all weld metal

Yield stress, MPa	600
Tensile strength, MPa	650
Elongation, %	24

Charpy V

Test temps, °C	Impact values, J
0	100
-20	90
-51	60

Approvals

ABS	3H5, 3Y
BV	3Y HH
DB	10.039.17
DB	20.039.02
DNV	3 YH10
DS	EN 1599
LR	3, 3Y H15
Sepros	UNA 481555
SS	EN 1599
UDT	DIN 8529
Ü	10.039/3
VdTÜV	01027

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	55-80	22	0.62	136.0	0.7	38
2.5	350	75-100	22	0.62	73.0	0.9	55
3.2	450	105-140	23	0.65	32.0	1.3	86
4.0	450	140-190	23	0.65	20.5	1.8	97
5.0	450	190-260	24	0.68	14.0	2.6	100
6.0	450	240-340	24	0.69	10.0	3.6	103