

OK 74.46L

OK 74.46L is a 0.5Mo alloyed low hydrogen electrode for welding of similar alloy type creep resistant steels. The specially designed running characteristics make it suitable for welding joints in the inclined positions. OK 74.46L deposits a weld metal with good crack resistance and creep resistance upto 525°C.

Specifications	
Classifications	SFA/AWS A5.5 : E7018-A1 IS 1395 : E49BA126Fe
Approvals	IBR : E7018-A1 PDIL : E7018-A1

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+
Diffusible Hydrogen	< 4 ml/100g
Alloy Type	Mo alloyed
Coating Type	Lime Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
AWS			
PWHT 1 hour(s) 620 °C	470 MPa	550 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS		
PWHT	-20 °C	30 J

Typical Weld Metal Analysis %					
C	Mn	Si	S	P	Mo
0.06	0.70	0.30	0.020	0.025	0.55

Deposition Data	
Diameter	Current
2.5 x 350.0 mm	70-100 A
3.15 x 450.0 mm	90-150 A
4.0 x 450.0 mm	120-180 A
5.0 x 450.0 mm	160-250 A