

OK 73.68

OK 73.68 is a 2.5Ni alloyed hydrogen controlled electrode, specially designed for welding low alloy steels used for high ductility, toughness and resistance to the embrittlement effects at sub-zero temperatures. The weld metal is suitable for impact requirements down to -60°C. The composition of the weld metal is designed for good low temperature impact properties, even when welding vertically up. The alloy is also noted for its good corrosion resistance to sea water and sulphuric acid fumes.

Specifications

Classifications	SFA/AWS A5.5 : E8018-C1 IS 1395 : E55BC126Fe
Approvals	RDSO : B3

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

Welding Current	AC, DC+
Diffusible Hydrogen	< 5 ml/100g
Alloy Type	Ni alloyed
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
Stress Relieved 1 hour(s) 610 °C	490 MPa	570 MPa	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
Stress Relieved	-60 °C	95 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
0.08	0.90	0.35	2.30

Deposition Data

Diameter	Current
2.5 x 350 mm	50-90 A
3.15 x 450 mm	90-140 A
4.0 x 450 mm	140-190 A
5.0 x 450 mm	190-240 A