

## OK 73.08L

OK 73.08L is a Ni-Cu alloyed low hydrogen electrode, which deposits a weld metal with good corrosion resistance to sea water and flue gases. The weld metal has excellent mechanical properties. It is used for the welding of weather proof steel and ship's hull structural steel and shell plating of ice-breakers.

### Specifications

<b>Classifications</b>	SFA/AWS A5.5 : E8018-G IS 1395 : E55BG129Fe
<b>Welding Current</b>	AC, DC+
<b>Diffusible Hydrogen</b>	<5 ml/100g
<b>Alloy Type</b>	Ni-Cu alloyed
<b>Coating Type</b>	Basic

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS</b>			
As Welded	500 MPa	580 MPa	28 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>AWS</b>		
As Welded	-20 °C	120 J

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.10	1.20	0.40	0.020	0.025	0.45	0.10	0.004	0.002	0.45

### Deposition Data

Diameter	Current
2.5 x 350.0 mm	75-100 A
3.15 x 450.0 mm	100-140 A
4.0 x 450.0 mm	140-200 A
5.0 x 450.0 mm	190-270 A