

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

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	500 MPa	580 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
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