

OK 73.15

OK 73.15 is a basic electrode with very good welding characteristics. Its exceptional weldability is ideal for multiple applications including Pipe. The electrode has a classification of AWS 8018-C3 H4R and gives a weld metal alloyed with about 0.9% Ni. It fulfils impact requirements down to - 50 °C. The low moisture absorption coating gives less than 4 ml diffusible hydrogen / 100 g welded metal. Weld metal recovery is above 120 % for the main diameters. OK 73.15 is HIC test compliant as per NACE TM0284 & SSC test compliant as per NACE TM0177.

Specificaties

Classificaties	SFA/AWS A5.5M : E5518-C3 SFA/AWS A5.5 : E8018-C3 H4R EN ISO 2560-A : E 46 5 1Ni B 4 2 H5
Goedkeuringen	DNV-GL : 4 Y46H5

Goedkeuringen zijn gebaseerd op fabriekslocatie. Neem contact op met ESAB voor meer informatie.

Lasstroom	DC+(-)
Diffundeerbaar waterstof	< 4.0 ml/100g
Legering Type	Low alloyed (0.9 % Ni)
Coating Type	Basic covering

Typische Mechanische Eigenschappen

Conditionering	Rekgrens	Treksterkte	Rek
AWS			
Zoals gelast	500 MPa	600 MPa	29 %
PWHT 1 hour(s) 620 °C	500 MPa	580 MPa	27 %
PWHT 6 hour(s) 620 °C	490 MPa	580 MPa	27 %
PWHT 10 hour(s) 620 °C	500 MPa	590 MPa	27 %

Kerfslageigenschappen

Conditionering	Testtemperatuur	Kerfslagwaarde
AWS		
PWHT	-60 °C	50 J
Zoals gelast	-40 °C	90 J
PWHT	-50 °C	70 J
PWHT	-50 °C	50 J
PWHT	-40 °C	70 J
Zoals gelast	-60 °C	60 J
Zoals gelast	-50 °C	70 J
PWHT	-50 °C	60 J

Typische lasmetaalanalyse (%)

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.07	1.10	0.35	0.014	0.009	0.90	0.08	0.15	0.01

Neersmeltgegevens

Diameter	Ampère	Volt	Rendement (%)	Smelttijd per elektrode bij 90% I max	Neersmelt
2.5 x 350.0 mm	65-110 A	20 V	60 %	57 sec	0.9 kg/h

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Neersmeltgegevens

Diameter	Ampère	Volt	Rendement (%)	Smelttijd per elektrode bij 90% I max	Neersmelt
3.2 x 350.0 mm	85-150 A	22 V	63 %	63 sec	1.3 kg/h
3.2 x 450.0 mm	85-150 A	22 V	63 %	64 sec	1.3 kg/h
4.0 x 350.0 mm	115-190 A	25 V	65 %	93 sec	1.8 kg/h
4.0 x 450.0 mm	115-190 A	25 V	66 %	95 sec	1.8 kg/h
5.0 x 450.0 mm	155-280 A	28 V	66 %	93 sec	2.7 kg/h