

OK 73.35

OK 73.35 is a low-hydrogen all-positional AC/DC electrode conforming to the AWS E 7018-C3L classification.

Specifications

Classifications	SFA/AWS A5.5 : E 7018-C3L EN ISO 2560-A : E 46 5 1Ni B 32 H5
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Welding Current	AC, DC+-
Alloy Type	1% Ni
Coating Type	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	500 MPa	590 MPa	28 %
ISO			
As Welded	500 MPa	590 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	-51 °C	80 J
ISO		
As Welded	-50 °C	80 J

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	65-110 A	20 V	60 %	69	57 sec	0.9 kg/h
3.2 x 450.0 mm	90-135 A	23 V	61 %	36	61 sec	1.3 kg/h
4.0 x 450.0 mm	100-190 A	24 V	61 %	24	95 sec	1.7 kg/h
5.0 x 450.0 mm	175-255 A	26 V	61 %	15	100 sec	2.3 kg/h