

## OK 75.75

OK 75.75 is an LMA electrode dried to a low moisture content and suitable for the welding of high-strength, low-alloyed steels, at room temperature or with moderate preheating.

| Specifications  |                                                                      |
|-----------------|----------------------------------------------------------------------|
| Classifications | SFA/AWS A5.5 : E11018-G<br>EN ISO 18275-A : E 69 4 Mn2NiCrMo B 42 H5 |
| Approvals       | ABS : E11018-G<br>CE : EN 13479<br>DB : 10.039.19<br>VdTÜV : 01028   |

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

|                     |                                            |
|---------------------|--------------------------------------------|
| Welding Current     | DC+                                        |
| Diffusible Hydrogen | < 5.0 ml/100g                              |
| Alloy Type          | Low alloyed (2.4 % Ni, 0.4 % Cr, 0.4 % Mo) |
| Coating Type        | Basic covering                             |

| Typical Tensile Properties |                |                  |            |
|----------------------------|----------------|------------------|------------|
| Condition                  | Yield Strength | Tensile Strength | Elongation |
| ISO                        |                |                  |            |
| As Welded                  | 780 MPa        | 830 MPa          | 20 %       |

| Typical Charpy V-Notch Properties |                     |              |
|-----------------------------------|---------------------|--------------|
| Condition                         | Testing Temperature | Impact Value |
| ISO                               |                     |              |
| As Welded                         | -40 °C              | 60 J         |

| Typical Weld Metal Analysis % |      |      |     |     |     |
|-------------------------------|------|------|-----|-----|-----|
| C                             | Mn   | Si   | Ni  | Cr  | Mo  |
| 0.05                          | 1.61 | 0.36 | 2.4 | 0.4 | 0.4 |

| Deposition Data |           |         |                |                                        |                 |
|-----------------|-----------|---------|----------------|----------------------------------------|-----------------|
| Diameter        | Current   | Voltage | Efficiency (%) | Fusion time per electrode at 90% I max | Deposition Rate |
| 2.5 x 350.0 mm  | 70-110 A  | 22 V    | 67 %           | 54 sec                                 | 1.0 kg/h        |
| 3.2 x 450.0 mm  | 100-150 A | 23 V    | 67 %           | 80 sec                                 | 1.4 kg/h        |
| 4.0 x 450.0 mm  | 135-200 A | 24 V    | 65 %           | 92 sec                                 | 1.9 kg/h        |
| 5.0 x 450.0 mm  | 180-260 A | 25 V    | 63 %           | 105 sec                                | 2.5 kg/h        |