OK 73.79

Nickel alloyed basic AC/DC low hydrogen electrode for MMA welding of 3.5 % Ni steels with impact requirements down to -101 °C, e.g. in LPG tanks for ethane, chemical plants etc.

Specifications	
Classifications	SFA/AWS A5.5 : E8016-C2 EN ISO 2560-A : E 46 6 3 Ni B 12 H5
Approvals	DNV-GL : 5 Y46H5 RS : 5Y46 H5

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

Welding Current	AC, DC+-
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	Low alloyed (3.5 % Ni)
Coating Type	Basic covering

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	540 MPa	630 MPa	27 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
As Welded	-101 °C	35 J
As Welded	-60 °C	130 J
As Welded	-75 °C	110 J

Typical Weld Metal Analysis %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**
0.06	0.8	0.36	3.37	0.05	0.01

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
2.5 x 350.0 mm	70-110 A	25 V	60 %	60 sec	0.8 kg/h
3.2 x 450.0 mm	80-150 A	25 V	60 %	77 sec	1.5 kg/h
4.0 x 450.0 mm	90-190 A	27 V	63 %	88 sec	1.8 kg/h
5.0 x 450.0 mm	110-240 A	29 V	60 %	100 sec	2.1 kg/h