OK 74.79

OK 74.79 is a high recovery, LMA electrode suitable for welding high tensile steels for structures. Very suitable for enclosed joint welding of rail and for cladding on rail when a hardness of about 250 HV is desired. The moisture content of the coating is very low, which makes OK 74.79 suitable when preheating cannot be applied. The risk of grain boundary cracking is very low when welding with OK 74.79.

Welding Current	AC, DC+
Alloy Type	High-tensile
Coating Type	Zircon Basic

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
Stress Relieved	600 MPa	670 MPa	23 %
ISO			
As Welded	600 MPa	670 MPa	23 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
Stress Relieved	-60 °C	25 J
Stress Relieved	-40 °C	37 J
Stress Relieved	-20 °C	47 J
Stress Relieved	20 °C	80 J
ISO		
As Welded	20 °C	105 J
As Welded	-40 °C	50 J
As Welded	-20 °C	60 J
As Welded	-60 °C	30 J

Deposition Data						
Diameter	**Current**	**Voltage**	**kg weld metal/kg electrodes**	**Number of electrodes/kg weld metal**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
3.2 x 450 mm	100-160 A	23 V	0.66	24.0	75 sec	2.00 kg/h
4.5 x 450 mm	200-300 A	31 V	0.67	12.0	77 sec	3.90 kg/h
5.6 x 450 mm	290-420 A	40 V	0.67	8.0	72 sec	6.30 kg/h