

OK 74.70

OK 74.70 is used for welding high tensile low alloyed steels. The electrode is designed for welding different constructions including pipelines made from pipe steel in grades API 5LX60, 5LX65, 5LX70.

Specifications

Classifications	SFA/AWS A5.5 : E8018-G EN ISO 2560-A : E 50 4 Z B 42 H5
Approvals	NAKS/HAKC : 3.2-4.0 mm

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 (0.5 % Mo)
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	550 MPa	650 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-40 °C	90 J
As Welded	-20 °C	120 J

Typical Weld Metal Analysis %

C	Mn	Si	Mo
0.08	1.5	0.4	0.45

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 350.0 mm	80-140 A	23 V	58 %	63 sec	1.14 kg/h
3.2 x 450.0 mm	80-140 A	23 V	61 %	91 sec	1.6 kg/h
4.0 x 450.0 mm	110-190 A	24 V	63 %	93 sec	1.66 kg/h