

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 |