

OK 73.68

Nickel alloyed basic AC/DC electrode for welding low alloyed steels with impact requirements down to -60 °C, e.g. in offshore/onshore applications. The electrode is CTOD-tested.

Specifications	
Classifications	SFA/AWS A5.5 : E8018-C1 EN ISO 2560-A : E 46 6 2Ni B 32 H5
Approvals	ABS : 3Y400 H5 BV : 5Y40M H5 CE : EN 13479 DNV-GL : 5 Y46H5 LR : 5Y42 H5 NAKS/HAKC : 2.5 - 4.0 mm PRS : 5Y42 H5 RS : 5Y46M H5* VdTUV : 01529

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 (2.5 % Ni)
Coating Type	Basic covering

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
AWS			
Stress Relieved 1 hour(s) 620 °C	500 MPa	600 MPa	28 %
ISO			
As Welded	540 MPa	635 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS		
Stress Relieved	-60 °C	85 J
ISO		
As Welded	-20 °C	155 J
As Welded	-60 °C	99 J
As Welded	-40 °C	117 J

Typical Weld Metal Analysis %					
C	Mn	Si	Ni	Cr	Mo
0.05	1	0.35	2.4	0.02	0.01

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	23 V	62 %	55 sec	0.9 kg/h
3.2 x 450.0 mm	105-150 A	23 V	62 %	81 sec	1.4 kg/h

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Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
4.0 x 450.0 mm	140-190 A	23 V	65 %	88 sec	2.0 kg/h
5.0 x 450.0 mm	190-270 A	27 V	65 %	104 sec	2.5 kg/h