

## OK 73.15

OK 73.15 is a basic electrode with very good welding characteristics. Its exceptional weldability is ideal for multiple applications including Pipe. The electrode has a classification of AWS 8018-C3 H4R and gives a weld metal alloyed with about 0.9% Ni. It fulfils impact requirements down to - 50 °C. The low moisture absorption coating gives less than 4 ml diffusible hydrogen / 100 g welded metal. Weld metal recovery is above 120 % for the main diameters. OK 73.15 is HIC test compliant as per NACE TM0284 & SSC test compliant as per NACE TM0177.

### Tekniska data

|                         |                                                                                                |
|-------------------------|------------------------------------------------------------------------------------------------|
| <b>Klassificeringar</b> | SFA/AWS A5.5M : E5518-C3<br>SFA/AWS A5.5 : E8018-C3 H4R<br>EN ISO 2560-A : E 46 5 1Ni B 4 2 H5 |
| <b>Godkännanden</b>     | DNV-GL : 4 Y46H5                                                                               |

Godkännanden baseras på fabriksplats. Kontakta ESAB för mer information.

|                           |                        |
|---------------------------|------------------------|
| <b>Svetsström</b>         | DC+(-)                 |
| <b>Diffunderbart väte</b> | < 4.0 ml/100g          |
| <b>Legeringstyp</b>       | Low alloyed (0.9 % Ni) |
| <b>Höjljtyp</b>           | Basic covering         |

### Typiska mekaniska värden

| Villkor                   | Sträckgräns | Brottgräns | Förlängning |
|---------------------------|-------------|------------|-------------|
| <b>AWS</b>                |             |            |             |
| Helsvetsgods              | 500 MPa     | 600 MPa    | 29 %        |
| PWHT<br>1 hour(s) 620 °C  | 500 MPa     | 580 MPa    | 27 %        |
| PWHT<br>6 hour(s) 620 °C  | 490 MPa     | 580 MPa    | 27 %        |
| PWHT<br>10 hour(s) 620 °C | 500 MPa     | 590 MPa    | 27 %        |

### Slagseghetsdata Charpy V

| Villkor      | Provningstemperatur | Slagseghet |
|--------------|---------------------|------------|
| <b>AWS</b>   |                     |            |
| PWHT         | -60 °C              | 50 J       |
| Helsvetsgods | -40 °C              | 90 J       |
| PWHT         | -50 °C              | 70 J       |
| PWHT         | -50 °C              | 50 J       |
| Helsvetsgods | -50 °C              | 70 J       |
| PWHT         | -40 °C              | 70 J       |
| Helsvetsgods | -60 °C              | 60 J       |
| PWHT         | -50 °C              | 60 J       |

### Svetsgodsanalys %

| C    | Mn   | Si   | S     | P     | Ni   | Cr   | Mo   | V    |
|------|------|------|-------|-------|------|------|------|------|
| 0.07 | 1.10 | 0.35 | 0.014 | 0.009 | 0.90 | 0.08 | 0.15 | 0.01 |

### Insmålningsdata

| Diameter       | Ström    | Bågspänning | Verkningsgrad (%) | Smälttid per elektrod<br>vid 90% av maxström | Insvetstal vid 90 % I<br>max |
|----------------|----------|-------------|-------------------|----------------------------------------------|------------------------------|
| 2.5 x 350.0 mm | 65-110 A | 20 V        | 60 %              | 57 sec                                       | 0.9 kg/h                     |
| 3.2 x 350.0 mm | 85-150 A | 22 V        | 63 %              | 63 sec                                       | 1.3 kg/h                     |

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|----------------|-----------|-------------|-------------------|----------------------------------------------|------------------------------|
| 3.2 x 450.0 mm | 85-150 A  | 22 V        | 63 %              | 64 sec                                       | 1.3 kg/h                     |
| 4.0 x 350.0 mm | 115-190 A | 25 V        | 65 %              | 93 sec                                       | 1.8 kg/h                     |
| 4.0 x 450.0 mm | 115-190 A | 25 V        | 66 %              | 95 sec                                       | 1.8 kg/h                     |
| 5.0 x 450.0 mm | 155-280 A | 28 V        | 66 %              | 93 sec                                       | 2.7 kg/h                     |