

OK 73.09

OK 73.09 is a NiCu alloyed LMA electrode, giving good corrosion resistance to sea water , for the welding of weathering steels.

Specifications

Classifications	SFA/AWS A5.5 : E8018-G EN ISO 2560-A : E 46 3 Z B 42 H5
Approvals	CE : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Diffusible Hydrogen	<5.0 ml/100g
Alloy Type	Weathering steel
Coating Type	Lime Basic

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	80-110 A	22 V	66 %	68	57 sec	0.9 kg/h
3.2 x 450.0 mm	100-140 A	22 V	67 %	33	87 sec	1.3 kg/h
4.0 x 450.0 mm	130-180 A	22 V	66 %	22	99 sec	1.6 kg/h
5.0 x 450.0 mm	190-240 A	23 V	68 %	14	108 sec	2.4 kg/h