OK 73.08



NiCu-alloyed electrode which deposits a weld metal with good corrosion resistance to sea water and flue gases, for the welding of weathering steels, e g Cor-Ten steel and ship's hull structural steel. The weld metal has excellent mechanical properties.

Specifications	
Classifications	SFA/AWS A5.5 : E8018-G EN ISO 2560-A : E 46 5 Z B 32
Approvals	ABS : 3Y H10 BV : 3Y H10 CE : EN 13479 DB : 10.039.20 DNV : 3 YH10 LR : 3Y H10 UKCA : EN 13479 VdTÜV : 02115

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

Welding Current	AC, DC+
Diffusible Hydrogen	< 10.0 ml/100g
Alloy Type	Low alloyed (0.7 % Ni, 0.4 % Cu)
Coating Type	Basic covering
Min AC OCV	65

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	520 MPa	610 MPa	30 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	-50 °C	100 J

Typical Weld Metal Analysis %				
C	**Mn**	**Si**	**Ni**	**Cu**
0.06	1.2	0.5	0.7	0.5

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 350 mm	80-115 A	21 V	62 %	59 sec	0.9 kg/h
3.2 x 350 mm	100-150 A	23 V	62 %	68 sec	1.2 kg/h
3.2 x 450 mm	100-150 A	22 V	66 %	90 sec	1.3 kg/h
4.0 x 450 mm	130-200 A	23 V	68 %	100 sec	1.8 kg/h