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.

Specifications	
Classifications	SFA/AWS A5.5M : E5518-C3 SFA/AWS A5.5 : E8018-C3 H4R EN ISO 2560-A : E 46 5 1Ni B 4 2 H5
Approvals	CE : EN 13479 DNV-GL : 4 Y46H5 UKCA : EN 13479

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

Welding Current	DC+(-)
Diffusible Hydrogen	< 4.0 ml/100g
Alloy Type	Low alloyed (0.9 % Ni)
Coating Type	Basic covering

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	500 MPa	600 MPa	29 %
PWHT 10 hour(s) 620 °C	500 MPa	590 MPa	27 %
PWHT 1 hour(s) 620 °C	500 MPa	580 MPa	27 %
PWHT 6 hour(s) 620 °C	490 MPa	580 MPa	27 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
AWS		
As Welded	-40 °C	90 J
PWHT 10 hour(s) 620 °C	-40 °C	70 J
As Welded	-50 °C	70 J
PWHT 10 hour(s) 620 °C	-50 °C	50 J
PWHT 1 hour(s) 620 °C	-50 °C	70 J
PWHT 6 hour(s) 620 °C	-50 °C	60 J
As Welded	-60 °C	60 J
PWHT 6 hour(s) 620 °C	-60 °C	50 J

Typical Weld Metal Analysis %								
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

OK 73.15

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 350 mm	65-110 A	20 V	60 %	57 sec	0.9 kg/h
3.2 x 350 mm	85-150 A	22 V	63 %	63 sec	1.3 kg/h
3.2 x 450 mm	85-150 A	22 V	63 %	64 sec	1.3 kg/h
4.0 x 350 mm	115-190 A	25 V	65 %	93 sec	1.8 kg/h
4.0 x 450 mm	115-190 A	25 V	66 %	95 sec	1.8 kg/h
5.0 x 450 mm	155-280 A	28 V	66 %	93 sec	2.7 kg/h