OK 74.46



OK 74.46 is an LMA electrode alloyed with 0.5% Mo for welding steels for pressure vessels. The running characteristics make it suitable for welding joints in the inclined positions. The composition of the coating is adapted for welding with low currents, making it very suitable for the welding of pipes.

Specifications	
Classifications	SFA/AWS A5.5 : E7018-A1 EN ISO 3580-A : E Mo B 3 2 H5
Approvals	CE : EN 13479 DB : 10.039.45 UKCA : EN 13479 VdTÜV : 01043

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

Welding Current	AC, DC+
Diffusible Hydrogen	< 5ml/100g
Alloy Type	Low alloyed (0.5 % Mo)
Coating Type	Basic covering
Min AC OCV	65

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
PWHT 1 hour(s) 620 °C	460 MPa	560 MPa	27 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
PWHT 1 hour(s) 620 °C	20 °C	175 J

Typical Weld Metal Analysis %				
C	**Mn**	**Si**	**Cr**	**Mo**
0.06	0.74	0.51	0.09	0.55

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.0 x 300 mm	55-80 A	22 V	59 %	40 sec	0.7 kg/h
2.5 x 350 mm	75-110 A	23 V	59 %	55 sec	0.9 kg/h
3.2 x 350 mm	105-150 A	23 V	54 %	66 sec	1.0 kg/h
3.2 x 450 mm	105-150 A	25 V	59 %	81 sec	1.2 kg/h
4.0 x 450 mm	140-200 A	26 V	65 %	90 sec	1.8 kg/h
5.0 x 450 mm	190-270 A	27 V	65 %	104 sec	2.4 kg/h