# OK 74.86 TENSITRODE




A basic coated electrode for steels and castings with U.T.S of min 690 MPa.

| Specifications | |
|---|---|
| **Classifications** | SFA/AWS A5.5 : E10018-D2<br>EN ISO 18275-A : E 62 4 Mn1NiMo B T 32 H5 |
| **Approvals** | ABS : 3YQ620 H5<br>CE : EN 13479<br>UKCA : EN 13479 |

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

| | |
|---|---|
| **Welding Current** | AC, DC+ |
| **Diffusible Hydrogen** | < 5.0 ml/100 g |
| **Alloy Type** | Low alloyed (1.8 % Mn, 0.4 % Mo) |
| **Coating Type** | Basic covering |
| **Min AC OCV** | 65 |

| Typical Tensile Properties | | | |
|---|---|---|---|
| **Condition** | **Yield Strength** | **Tensile Strength** | **Elongation** |
| **ISO** | | | |
| Stress Relieved<br>1 hour(s) 590 °C | 630 MPa | 720 MPa | 25 % |

| Typical Charpy V-Notch Properties | | |
|---|---|---|
| **Condition** | **Testing Temperature** | **Impact Value** |
| **ISO** | | |
| Stress Relieved<br>1 hour(s) 590 °C | -40 °C | 75 J |
| Stress Relieved<br>1 hour(s) 590 °C | -50 °C | 60 J |

| Typical Weld Metal Analysis % | | | | | |
|---|---|---|---|---|---|
| **C** | **Mn** | **Si** | **Ni** | **Cr** | **Mo** |
| 0.06 | 1.74 | 0.37 | 0.83 | 0.04 | 0.34 |

| Deposition Data | | | | | |
|---|---|---|---|---|---|
| **Diameter** | **Current** | **Voltage** | **Efficiency (%)** | **Fusion time per electrode at 90% I max** | **Deposition Rate** |
| 2.5 x 350 mm | 75-100 A | 21.6 V | 61 % | 60.1 sec | 0.86 kg/h |
| 3.2 x 350 mm | 110-140 A | 23 V | 63 % | 63 sec | 1.35 kg/h |
| 3.2 x 450 mm | 110-140 A | 22 V | 65 % | 85.6 sec | 1.2 kg/h |
| 4.0 x 450 mm | 150-190 A | 22.8 V | 62 % | 93.4 sec | 1.72 kg/h |
| 5.0 x 450 mm | 190-260 A | 22.8 V | 68 % | 92.6 sec | 2.72 kg/h |