

OK 74.46

Type Lime-basic

SMAW

E7018-A1

Description

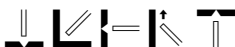
OK 74.46 is an LMA electrode alloyed with 0.5% Mo for welding steels for pressure vessels. The running characteristics make it suitable for welding joints in inclined positions. The composition of the coating is adapted for welding with low currents, making OK 74.46 very suitable for the welding of pipes.

Recovery

115%

Welding current

DC+, AC OCV 65 V



Classifications

SFA/AWS A5.5	E7018-A1
EN 1599	E Mo B 42 H5
ISO 3580	E Mo B 20

Typical all weld metal composition, %

C	Si	Mn	Mo
0.06	0.5	0.7	0.5

Typical mech. properties all weld metal

Yield stress, MPa	460
Tensile strength, MPa	560
Elongation, %	27

Charpy V

Test temps, °C	Impact values, J
+20	175
0	>31

Approvals

CL	EN 1599
SFS	EN 1599
UDT	DIN 8575
VdTÜV	01043

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.0	300	55-80	22	0.59	136.0	0.7	40
2.5	350	75-110	23	0.59	73.0	0.9	55
3.2	350	105-150	23	0.54	53.0	1.0	66
3.2	450	105-150	25	0.59	37.0	1.2	81
4.0	450	140-200	26	0.65	22.5	1.8	90
5.0	450	190-270	27	0.65	14.5	2.4	104
6.0	450	260-370	28	0.65	10.0	3.4	108