

OK 75.75

Type Lime-basic

SMAW
E11018-G

Description

OK 75.75 is an LMA electrode dried to a very low moisture content and suitable for the welding of high-strength, low-alloyed steels, at room temperature or with moderate preheating.

Recovery

125%

Welding current

DC+



Classifications

SFA/AWS A5.5 E11018-G
EN 757 E 69 4 Mn2NiCrMoB 42 H5

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo
0.06	0.3	1.7	0.4	2.2	0.4

Typical mech. properties all weld metal

Yield stress, MPa 755
Tensile strength, MPa 820
Elongation, % 20

Charpy V

Test temps, °C	Impact values, J
+20	115
-20	85
-40	70
-51	55
-60	45

Approvals

ABS	E11018-G
DB	10.039.19
RS	4Y62HH
Sepros	UNA 485155
UDT	DIN 8529
Ü	10.039/3
VdTÜV	01028

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of elec- trodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.5	350	70-110	22	0.67	66.0	1.0	54
3.2	450	100-150	23	0.67	31.5	1.4	80
4.0	450	135-200	24	0.65	21.0	1.9	92
5.0	450	180-260	25	0.63	12.0	2.5	105