

OK 74.70

Lime-basic

SMAW

E8018-G

Description

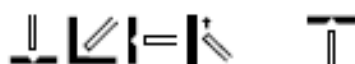
OK 74.70 is an LMA electrode used for welding high strength, low-alloyed steel. The electrode is designed for various applications, including pipelines.

Recovery

115%

Welding current

DC+(-)



Classifications

SFA/AWS A5.5	E8018-G
EN 499	E 50 4 MnMo B 42 H5

Typical all weld metal composition, %

C	Si	Mn	Mo
0.08	0.4	1.5	0.4

Typical properties of all weld metal

Yield stress, Mpa	540
Tensile strength, MPa	630
Elongation, %	26

Charpy V

Test temps, °C	Impact values, J
-20	110
-40	80
-60	50

Approvals

Sepros	UNA 485155
VNIIST	

Packing/Ordering Information

Part Number	Dia mm	Inner Carton	Carton Weight (kg)	Pallet Weight (kg)
74703230G0	3.2	1.7	10.2	683.4
74704040G0	4.0	2.2	13.2	646.8

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, (secs)/ Electrode
3.2	350	80-140	23	0.58	50.0	1.14	63
4.0	350	90-190	23	0.61	31.6	1.60	71
4.0	450	90-190	24	0.63	23.4	1.66	93
5.0	450	150-250	23	0.65	15.0	2.30	102