

OK 74.78

Lime-basic

SMAW

E9018-D1

Description

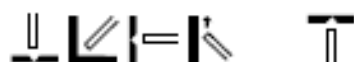
OK 74.78 is an LMA electrode suitable for welding high tensile steels used in low-temperature applications. Good notch toughness down to -40°C. Very suitable for both the enclosed welding and cladding of rails, when a hardness of about 250 HV is required. The moisture content of the coating is very low, which makes OK 74.78 suitable when preheating cannot be applied.

Recovery

125%

Welding current

AC, DC+ OCV 70 V



Packing/Ordering Information

Part Number	Dia mm	Inner Carton	Carton Weight (kg)	Pallet Weight (kg)
7478253ND0	2,5	3,6	10,8	756,0
7478324NM0	3,2	5,2	15,6	842,4
7478404NM0	4,0	5,0	15,0	810,0

Classifications

SFA/AWS A5.5	E9018-D1
EN 757	E 55 4 MnMo B 32H5

Typical all weld metal composition, %

C	Si	Mn	Mo
0.06	0.4	1.5	0.4

Typical properties of all weld metal

Yield stress, Mpa	600
Tensile strength, MPa	650
Elongation, %	24

Charpy V

Test temps, °C	Impact values, J
0	100
-20	90
-51	60

Approvals

ABS	3H5, 3Y
BV	3Y HH
DB	10.039.17
DB	20.039.02
DNV	3 YH10
CE	EN 13479
LR	3, 3Y H15
Sepros	UNA 409819
VdTUV	01027

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
2.0	300	55-80	22	0,62	136,0	0,7	38
2.5	350	75-100	22	0,62	73,0	0,9	55
3.2	450	105-140	23	0,65	32,0	1,3	86
4.0	450	140-190	23	0,65	20,5	1,8	97
5.0	450	190-260	24	0,68	14,0	2,6	100
6.0	450	240-340	24	0,69	10,0	3,6	103