OK 73.08

NiCu-alloyed electrode which deposits a weld metal with good corrosion resistance to sea water and flue gases, for the welding of weathering steels, e g Cor-Ten steel and ship's hull structural steel. The weld metal has excellent mechanical properties.

Classifications	SFA/AWS A5.5 : E8018-G EN ISO 2560-A : E 46 5 Z B 32
Approvals	ABS 3Y H10 BV 3Y H10 CE EN 13479 DB 10.039.20 DNV-GL 3 YH10 LR 3Y H10 RS 3Y H10 VdTÜV 02115

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

Welding Current	AC, DC+
Diffusible Hydrogen	< 10.0 ml/100g
Alloy Type	Low alloyed (0.7 % Ni, 0.4 % Cu)
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	520 MPa	610 MPa	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-50 °C	100 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cu
0.06	1.1	0.4	0.7	0.4

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 350.0 mm	80-115 A	21 V	66.0	59 sec	62 %	0.9 kg/h
3.2 x 350.0 mm	100-150 A	23 V	43	68 sec	62 %	1.2 kg/h
3.2 x 450.0 mm	100-150 A	22 V	30.5	90 sec	66 %	1.3 kg/h
4.0 x 450.0 mm	130-200 A	23 V	20.0	100 sec	68 %	1.8 kg/h
5.0 x 450.0 mm	190-280 A	27 V	13.5	106 sec	70 %	2.6 kg/h

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