

OK 74.70



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

Classifications:	SFA/AWS A5.5:E8018-G, EN ISO 2560-A:E 50 4 Z B 42 H5
Approvals:	NAKS/HAKC 3.2-4.0 mm

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

Welding Current:	DC+(-)
Diffusible Hydrogen:	<5.0 ml/100g
Alloy Type:	0.5% Mo
Coating Type:	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	550 MPa	650 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	-20 °C	120 J
As welded	-40 °C	90 J

Typical Weld Metal Analysis %

C	Mn	Si	Mo
0.08	1.5	0.4	0.45

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
3.2 x 350 mm	80-140 A	23 V	0.58	50	63 s	1.14 kg/h
3.2 x 450 mm	80-140 A	23 V	0.61	25	91 s	1.6 kg/h
4.0 x 450 mm	90-190 A	24 V	0.63	24	93 s	1.66 kg/h