

# OK 73.08



OK 73.08 is a NiCu-alloyed LMA electrode, which deposits a weld metal with good corrosion resistance to sea-water and flue gases, for the welding of weatherproof steel and for ship's hull structural steel. The weld metal has excellent mechanical properties. It is particularly suitable for welding the shell plating of ice-breakers and other ships, which work under conditions where the protective paint coating wears off.

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

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

<b>Welding Current:</b>	AC, DC+
<b>Diffusible Hydrogen:</b>	< 10.0 ml/100g
<b>Alloy Type:</b>	Weathering steel
<b>Coating Type:</b>	Lime Basic

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As welded	520 MPa	610 MPa	30 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
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	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 350 mm	80-115 A	21 V	0.62	66.0	59 s	0.90 kg/h
3.2 x 350 mm	100-150 A	23 V	0.62	43	68 s	1.2 kg/h
3.2 x 450 mm	100-150 A	22 V	0.66	30.5	90 s	1.30 kg/h
4.0 x 450 mm	130-200 A	23 V	0.68	20.0	100 s	1.80 kg/h
5.0 x 450 mm	190-280 A	27 V	0.70	13.5	106 s	2.60 kg/h