OK 74.46

OK 74.46 is an LMA electrode alloyed with 0.5% Mo for welding steels for pressure vessels. The running characteristics make it suitable for welding joints in inclined positions. The composition of the coating is adapted for welding with low currents, making OK 74.46 very suitable for the welding of pipes.

Classifications:	SFA/AWS A5.5:E7018-A1, EN ISO 3580-A:E Mo B 3 2 H5
Approvals:	CE EN 13479, VdTÜV 01043

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

Welding Current:	AC, DC+
Diffusible Hydrogen:	< 5ml/100g
Alloy Type:	Mo
Coating Type:	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
PWHT 620°C 1h	460 MPa	560 MPa	27 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
PWHT 620°C 1h	20 °C	175 J

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
0.05	0.77	0.38	0.04	0.57

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
2.0 x 300 mm	55-80 A	22 V	0.59	136.0	40 s	0.7 kg/h
2.5 x 350 mm	75-110 A	23 V	0.59	73.0	55 s	0.9 kg/h
3.2 x 350 mm	105-150 A	23 V	0.54	53	66 s	1 kg/h
3.2 x 450 mm	105-150 A	25 V	0.59	37.0	81 s	1.2 kg/h
4.0 x 450 mm	140-200 A	26 V	0.65	22.5	90 s	1.8 kg/h
5.0 x 450 mm	190-270 A	27 V	0.65	14.5	104 s	2.4 kg/h