

OK 75.75



OK 75.75 is an LMA electrode dried to a very low moisture content and suitable for the welding of high-strength, low-alloyed steels, at room temperature or with moderate preheating.

Classifications:	SFA/AWS A5.5:E11018-G, EN ISO 18275-A:E 69 4 Mn2NiCrMo B 42 H5
Approvals:	CE EN 13479, Seproz UNA 272580, ABS E11018-G, DB 10.039.19, VdTÜV 01028

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

Welding Current:	DC+
Diffusible Hydrogen:	<5.0 ml/100g
Alloy Type:	Low alloy steel
Coating Type:	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	780 MPa	830 MPa	20 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	-40 °C	60 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.05	1.61	0.36	2.32	0.32	0.33

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	70-110 A	22 V	0.67	66.0	54 s	1.00 kg/h
3.2 x 450 mm	100-150 A	23 V	0.67	31.5	80 s	1.40 kg/h
4.0 x 450 mm	135-200 A	24 V	0.65	21.0	92 s	1.90 kg/h
5.0 x 450 mm	180-260 A	25 V	0.63	12.0	105 s	2.50 kg/h