

# OK 73.68M

## A basic coated 2.5% Ni alloyed electrode for HSLA steels



Classification    AWS A5.5: E 8016-C1

### DESCRIPTION

OK 73.68M is a medium coated, hydrogen controlled, Ni based electrode yielding 2.5% Ni in the weld deposit, ideally suited for welding of fine grain steels and Ni steels especially for service temperature down to -59°C. The weld provides excellent strength combined with notch toughness at sub zero temperatures. OK 73.68M is superior in its class and can be operated on both AC and DC with excellent results.

**WELDING CURRENT:** DC+, AC 70V(min)

### TYPICAL APPLICATIONS

OK 73.68M is primarily designed for welding structures of low alloy steel applications including storage tanks, pressure vessels, containers and piping of liquified gases like propane, butane and ammonia. This particular alloy type is also noted for its good corrosion resistance to sea water and sulphuric acid fumes.

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.06	Ni	2.50	YS	490 N/mm <sup>2</sup>
Mn	0.90	Si	0.35	UTS	610 N/mm <sup>2</sup>
Cr	0.30	S	0.017	EL (L=4d)	26%
P	0.019			Impact (CVN) at -59°C	45J

### CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	70-110	130	520
3.15	450	95-130	95	380
4.00	450	130-170	60	240
5.00	450	180-250	35	140

**PACKING:** Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box.