

OK 73.68



A basic coated 2.5% Ni alloyed electrode for welding low alloy steels

Classification AWS A5.5: E 8018-C1
IS 1395: E55BC 129Fe



DESCRIPTION

OK 73.68 is a medium coated, hydrogen controlled, Ni based electrode specially designed for welding Ni alloy steels used for high ductility, toughness and resistance to the embrittlement effects of sub-zero temperatures. The weld deposit contains 2.5% Ni which imparts good resistance to brittle fracture down to -59°C. The weldmetal is designed to give good low temperature properties even when welded vertically up. OK 73.68 possesses excellent operating characteristics for its class and can be operated in both AC and DC.

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

TYPICAL APPLICATIONS

OK 73.68 is widely used for welding structures in low alloy steels, which must have good resistance to brittle fracture at temperatures down to - 60°C. 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 ²
Mn	0.90	S	0.017	UTS	610 N/mm ²
Si	0.35	P	0.019	EL (L=4d)	26%
				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	140	560
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.