

# OK 75.75



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

|                        |                                                                                 |
|------------------------|---------------------------------------------------------------------------------|
| <b>Classifications</b> | SFA/AWS A5.5 : E11018-G<br>EN ISO 18275-A : E 69 4 Mn2NiCrMo B 42 H5            |
| <b>Approvals</b>       | ABS E11018-G<br>CE EN 13479<br>DB 10.039.19<br>VdTUV 01028<br>Sepro UN A 272580 |

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

|                            |                                            |
|----------------------------|--------------------------------------------|
| <b>Welding Current</b>     | DC+                                        |
| <b>Diffusible Hydrogen</b> | < 5.0 ml/100g                              |
| <b>Alloy Type</b>          | Low alloyed (2.4 % Ni, 0.4 % Cr, 0.4 % Mo) |
| <b>Coating Type</b>        | Basic covering                             |

## Typical Tensile Properties

| Condition  | Yield Strength | Tensile Strength | Elongation |
|------------|----------------|------------------|------------|
| <b>ISO</b> |                |                  |            |
| As Welded  | 780 MPa        | 830 MPa          | 20 %       |

## Typical Charpy V-Notch Properties

| Condition  | Testing Temperature | Impact Value |
|------------|---------------------|--------------|
| <b>ISO</b> |                     |              |
| As Welded  | -40 °C              | 60 J         |

## Typical Weld Metal Analysis %

| C    | Mn   | Si   | Ni  | Cr  | Mo  |
|------|------|------|-----|-----|-----|
| 0.05 | 1.61 | 0.36 | 2.4 | 0.4 | 0.4 |

## Deposition Data

| Diameter       | Current   | Voltage | Number of electrodes/<br>kg weld metal | Fusion time per<br>electrode at 90% I<br>max | Deposition<br>Efficiency % | Deposition Rate @<br>90% I max |
|----------------|-----------|---------|----------------------------------------|----------------------------------------------|----------------------------|--------------------------------|
| 2.5 x 350.0 mm | 70-110 A  | 22 V    | 66.0                                   | 54 sec                                       | 67 %                       | 1.0 kg/h                       |
| 3.2 x 450.0 mm | 100-150 A | 23 V    | 31.5                                   | 80 sec                                       | 67 %                       | 1.4 kg/h                       |
| 4.0 x 450.0 mm | 135-200 A | 24 V    | 21.0                                   | 92 sec                                       | 65 %                       | 1.9 kg/h                       |
| 5.0 x 450.0 mm | 180-260 A | 25 V    | 12.0                                   | 105 sec                                      | 63 %                       | 2.5 kg/h                       |