

# OK 73.08



OK 73.08 is a Ni-Cu alloyed low hydrogen electrode, which deposits a weld metal with good corrosion resistance to sea water and flue gases. The weld metal has excellent mechanical properties. It is used for the welding of weather proof steel and ship's hull structural steel and shell plating of ice-breakers.

<b>Classifications:</b>	SFA/AWS A5.5:E8018-G, IS 1395:E55BG129Fe
<b>Welding Current:</b>	AC, DC+
<b>Diffusible Hydrogen:</b>	< 5 ml/100g
<b>Alloy Type:</b>	Ni-Cu alloyed
<b>Coating Type:</b>	Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS</b>			
As Welded	500 MPa	580 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
<b>AWS</b>		
As Welded	-20 °C	120 J

Typical Weld Metal Analysis %				
C	Mn	Si	Ni	Cu
0.07	1.20	0.40	0.45	0.45

Current Range	
Diameter	Current
2.5 x 350 mm	75-100 A
3.15 x 450 mm	100-140 A
4.0 x 450 mm	140-200 A
5.0 x 450 mm	190-270 A