OK 74.86 TENSITRODE



A basic coated electrode for steels and castings with U.T.S of min 690 MPa.

Specifications	
Classifications	SFA/AWS A5.5 : E10018-D2 EN ISO 18275-A : E 62 4 Mn1NiMo B T 32 H5
Approvals	ABS : 3YQ620 H5 CE : EN 13479 UKCA : EN 13479

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

Welding Current	AC, DC+
Diffusible Hydrogen	< 5.0 ml/100 g
Alloy Type	Low alloyed (1.8 % Mn, 0.4 % Mo)
Coating Type	Basic covering
Min AC OCV	65

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
Stress Relieved 1 hour(s) 590 °C	630 MPa	720 MPa	25 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
Stress Relieved 1 hour(s) 590 °C	-40 °C	75 J
Stress Relieved 1 hour(s) 590 °C	-50 °C	60 J

Typical Weld Metal Analysis %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**
0.06	1.74	0.37	0.83	0.04	0.34

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
2.5 x 350 mm	75-100 A	21.6 V	61 %	60.1 sec	0.86 kg/h
3.2 x 350 mm	110-140 A	23 V	63 %	63 sec	1.35 kg/h
3.2 x 450 mm	110-140 A	22 V	65 %	85.6 sec	1.2 kg/h
4.0 x 450 mm	150-190 A	22.8 V	62 %	93.4 sec	1.72 kg/h
5.0 x 450 mm	190-260 A	22.8 V	68 %	92.6 sec	2.72 kg/h