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.

Specifications	
Classifications	SFA/AWS A5.5 : E11018-G EN ISO 18275-A : E 69 4 Mn2NiCrMo B 42 H5
Approvals	ABS : E11018-G CE : EN 13479 DB : 10.039.19 VdTÜV : 01028

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

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

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	780 MPa	830 MPa	20 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
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	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
2.5 x 350 mm	70-110 A	22 V	67 %	54 sec	1.0 kg/h
3.2 x 450 mm	100-150 A	23 V	67 %	80 sec	1.4 kg/h
4.0 x 450 mm	135-200 A	24 V	65 %	92 sec	1.9 kg/h
5.0 x 450 mm	180-260 A	25 V	63 %	105 sec	2.5 kg/h