

OK 73.15



OK 73.15 is a basic electrode with very good welding characteristics. Its exceptional weldability is ideal for multiple applications including Pipe. The electrode has a classification of AWS 8018-C3 H4R and gives a weld metal alloyed with about 0.9% Ni. It fulfils impact requirements down to - 50 °C. The low moisture absorption coating gives less than 4 ml diffusible hydrogen / 100 g welded metal. Weld metal recovery is above 120 % for the main diameters. OK 73.15 is HIC test compliant as per NACE TM0284 & SSC test compliant as per NACE TM0177.

Classifications	SFA/AWS A5.5 : E8018-C3 H4R EN ISO 2560-A : E 46 5 1Ni B 4 2 H5
Approvals	ABS 3Y H5 DNV-GL 4 Y46H5

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

Welding Current	DC+(-)
Diffusible Hydrogen	< 4.0 ml/100g
Alloy Type	Low alloyed (0.9 % Ni)
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	500 MPa	600 MPa	29 %
PWHT 1hr 620°C	500 MPa	580 MPa	27 %
PWHT 6hr 620°C	490 MPa	580 MPa	27 %
PWHT 10hr 620°C	500 MPa	590 MPa	27 %

Typical Charpy V-Notch Properties

Condition
AWS
As Welded
As Welded
As Welded
PWHT 1hr 620°C
PWHT 6hr 620°C
PWHT 6hr 620°C
PWHT 10hr 620°C
PWHT 10hr 620°C

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.07	1.10	0.35	0.014	0.009	0.90	0.08	0.15	0.01

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 350.0 mm	65-110 A	20 V	69	57 sec	60 %	0.9 kg/h
3.2 x 350.0 mm	85-150 A	22 V	45	63 sec	63 %	1.3 kg/h
3.2 x 450.0 mm	85-150 A	22 V	43	64 sec	63 %	1.3 kg/h
4.0 x 350.0 mm	115-190 A	25 V	22	93 sec	65 %	1.8 kg/h
4.0 x 450.0 mm	115-190 A	25 V	21	95 sec	66 %	1.8 kg/h
5.0 x 450.0 mm	155-280 A	28 V	14	93 sec	66 %	2.7 kg/h