Product Data Sheet

OK 73.15

E 'Manual metal-arc welding'
ESAB Perstorp AB Sweden

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
P-O Oskarsson	Tero Borg	J-P Ernoult	EN007228	EN007082	2016-05-11	1 (2)

REASON FOR ISSUE

DNV-GL approval.

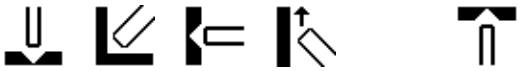
GENERAL

OK 73.15 is a basic electrode with very good welding characteristics. The electrode is of AWS 8018-G type and gives a weld metal alloyed with about 0.9% Ni. It fulfils impact requirements down to - 50 °C. The coating is of low moisture absorption type and the electrode gives less than 4 ml diffusible hydrogen / 100 g welded metal.

Polarity: DC+(-)

Alloy Type: Low alloyed
Coating Type: Basic
Diff Hydrogen: <4.0 ml/100g

WELDING POSITIONS



1 2 3 4 6

CLASSIFICATIONS Electrode

SFA/AWS A5.5	E8018-G H4R
EN ISO 2560-A	E 46 5 Mn1Ni B 4 2 H5

APPROVALS

ABS	3Y H5
DNV-GL	4 Y46H5

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.05	0.08
Si	0.25	0.55
Mn	1.40	1.70
P		0.015
S		0.015
Cr		0.19
Ni	0.85	0.99
Mo		0.19
V		0.049
Cu		0.29

MECHANICAL PROPERTIES OF WELD METAL

	ISO			AWS
	As welded			As welded
Properties	**Min**	**Max**	**Typ**	**Min**
Rp0.2 (MPa)	460		550	460
Rm (MPa)	530	680	630	550
A4 (%)				19
A5 (%)	20		25	
Charpy V at -50°C (J)	47		70	

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ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U	Welding
Ø x Length	Min	Max								Positions
2.5 x 350	55	110	3.3	104	0.63	80.6	1.00	46	25	1,2,3,4,6
3.2 x 450	80	145	4.8	118	0.64	32.6	1.30	85	22	1,2,3,4,6
4.0 x 450	110	200	7.1	118	0.64	21.9	1.90	86	23	1,2,3,4,6
5.0 x 450	155	290	11.3	123	0.67	13.2	2.90	93	23	1,2,3,4

W = Weight (kg / 100 electrodes)
η = Efficiency (g weld metal x 100 / g core wire)
N = Effective value (kg weld metal / kg electrodes)
B = Changes (number of electrodes / kg weld metal)
H = Deposit rate at 90% of max current (kg weld metal / hour arc time)
T = Fusion time at 90% of max current (s / electrode)
U = Arc voltage (V)