

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.

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 VdTUV 01028 Seproz UNA 272580

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

Typical Tensile Properties

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

Typical Charpy V-Notch Properties

Condition	Testing Temperature	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	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	70-110 A	22 V	66.0	54 sec	67 %	1.0 kg/h
3.2 x 450.0 mm	100-150 A	23 V	31.5	80 sec	67 %	1.4 kg/h
4.0 x 450.0 mm	135-200 A	24 V	21.0	92 sec	65 %	1.9 kg/h
5.0 x 450.0 mm	180-260 A	25 V	12.0	105 sec	63 %	2.5 kg/h