

OK 73.79



Nickel alloyed basic AC/DC low hydrogen electrode for MMA welding of 3.5 % Ni steels with impact requirements down to -101 °C, e.g. in LPG tanks for ethane, chemical plants etc.

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|------------------------|--|
| Classifications | SFA/AWS A5.5 : E8016-C2 EN ISO 2560-A : E 46 6 3 Ni B 12 H5 |
| Approvals | DNV-GL 5 Y46H5 RS 5Y46 H5 |

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

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|----------------------------|------------------------|
| Welding Current | AC, DC+- |
| Diffusible Hydrogen | < 5.0 ml/100g |
| Alloy Type | Low alloyed (3.5 % Ni) |
| Coating Type | Basic covering |

Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|------------|----------------|------------------|------------|
| ISO | | | |
| As Welded | 540 MPa | 630 MPa | 27 % |

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|------------|---------------------|--------------|
| ISO | | |
| As Welded | -60 °C | 130 J |
| As Welded | -75 °C | 110 J |
| As Welded | -101 °C | 35 J |

Typical Weld Metal Analysis %

| C | Mn | Si | Ni | Cr | Mo |
|------|-----|------|------|------|------|
| 0.06 | 0.8 | 0.36 | 3.37 | 0.05 | 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 | 70-110 A | 25 V | 76.0 | 60 sec | 60 % | 0.8 kg/h |
| 3.2 x 450.0 mm | 80-150 A | 25 V | 37.0 | 77 sec | 60 % | 1.5 kg/h |
| 4.0 x 450.0 mm | 90-190 A | 27 V | 26.0 | 88 sec | 63 % | 1.8 kg/h |
| 5.0 x 450.0 mm | 110-240 A | 29 V | 15.0 | 100 sec | 60 % | 2.1 kg/h |