

OK 74.46

A low alloy, low hydrogen electrode for MMAW



Classification AWS A5.5: E7018-A1
 DIN 8575: EKb Mo26
 IS: E49B-A1-26Fe

DESCRIPTION

OK 74.46 is a low alloy, low hydrogen electrode depositing a ductile and creep-resistant 0.5% Mo steel deposit for welding of Carbon-Molybdenum creep resistant pressure vessel steel. The specially designed slag system allows excellent running in all positions with minimum amount of spatter. OK 74.46 deposits a weld metal with good crack and creep resistance to temperature upto 525°C. The weld deposit is of radiographic quality.

APPROVALS: PDIL, IBR, RDSO

WELDING CURRENT: DC +, AC 70V

TYPICAL APPLICATIONS

OK 74.46 is especially designed for the welding of 0.5% Mo and 1% Cr-0.5 Mo steels. It is extensively used in high temperature pipelines; boiler tubes and plates where high creep resistance is a pre-requisite.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties		Hot Tensile Properties	
C	0.06	Mo	0.55	YS	460 N/mm ²	300°C	390 N/mm ²
Mn	0.75	S	0.018	UTS	550 N/mm ²	400°C	360 N/mm ²
Si	0.45	P	0.020	EL (L=4d)	28%	500°C	340 N/mm ²

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	75-110	135	540
3.15	450	105-150	95	380
4.00	450	140-200	60	240
5.00	450	190-270	35	140

PACKING: Electrodes are packed in cartons and four of these cartons are shrink wrapped in a box.