



OK 75.75

SMAW

OK 75.75 is an LMA electrode dried to a very low moisture content and is suitable for the welding of high-strength, low-alloyed steels at room temperature or with moderate preheating.

Recovery

125%

Welding Current

DC +



PACKING/ORDERING INFORMATION				
Part Number	Dia (mm)	Inner Carton (kg)	Carton Weight (kg)	Pallet Weight (kg)
VacPac				
75752530K0	2.5	0.6	5.4	361.8
75753240G0	3.2	2.2	13.2	646.8
75754040G0	4.0	2.2	13.2	646.8
75755040G0	5.0	2.1	12.6	617.4

CLASSIFICATIONS	APPROVALS	TYPICAL ALL WELD METAL COMPOSITION (%)		TYPICAL MECH. PROPERTIES ALL WELD METAL	
<u>SFA/AWS A5.5</u> E11018-G <u>EN 757</u> E 69 4 Mn2NiCrMoB 42 H5	ABS E11018-G	C	0.06	<u>Yield Stress, Mpa</u>	
	DB 10.039.19	Si	0.3	755	
	RS 4Y62HH	Mn	1.7	<u>Tensile Strength, Mpa</u>	
	Sepros UNA 409819	Cr	0.4	820	
	VdTUV 01028	Ni	2.2	<u>Elongation, %</u>	
	CE EN 13479	Mo	0.4	20	
				<u>Charpy V</u>	
				Test Temps, °C	Impact Values, J
				+20	115
				-20	85
				-40	70
				-51	55
				-60	45

WELDING PARAMETERS							
Diameter (mm)	Length (mm)	Welding Current, A	Arc Voltage, V	N. Kg Weld Metal/(kg) Electrodes	B. No. Of Electrodes/(kg) Weld Metal	H. Kg Weld Metal/(hour) Arc Time	T. Burn-off time, (secs)/ Electrode
2.5	350	70-110	22	0.67	66.0	1.0	54
3.2	450	100-150	23	0.67	31.5	1.4	80
4.0	450	135-200	24	0.65	21.0	1.9	92
5.0	450	180-260	25	0.63	12.0	2.5	105

