

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.

Specifications	
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 VdTÜV : 01028

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	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm	70-110 A	22 V	67 %	54 sec	1.0 kg/h
3.2 x 450 mm	100-150 A	23 V	67 %	80 sec	1.4 kg/h
4.0 x 450 mm	135-200 A	24 V	65 %	92 sec	1.9 kg/h
5.0 x 450 mm	180-260 A	25 V	63 %	105 sec	2.5 kg/h