



Product Data Sheet

OK 73.08

E 'Manual metal-arc welding'
ESAB Perstorp AB Sweden

Prepared by A-C Thorsson	Qualified by Tero Borg	Approved by J-P Ernoult	Reg no EN007253	Cancelling EN007076	Reg date 2016-05-17	Page 1 (2)
-----------------------------	---------------------------	----------------------------	--------------------	------------------------	------------------------	---------------

REASON FOR ISSUE

DNV-GL approval.

GENERAL

NiCu-alloyed electrode which deposits a weld metal with good corrosion resistance to sea water and flue gases, for the welding of weathering steels, e.g. Cor-Ten steel and ship's hull structural steel. The weld metal has excellent mechanical properties.

Min AC OCV: 65

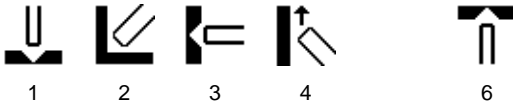
Polarity: AC, DC+

Alloy Type: Weathering steel

Coating Type: Lime Basic

Diff Hydrogen: < 10.0 ml/100g

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.5 E8018-G
EN ISO 2560-A E 46 5 Z B 32

APPROVALS

ABS	3Y H10
BV	3Y H10
CE	EN 13479
DB	10.039.20
DNV-GL	3 YH10
LR	3Ym H10
RS	3Y H10
VdTÜV	02115

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.02	0.10
Si	0.15	0.55
Mn	0.75	1.25
P		0.020
S		0.020
Cr		0.20
Ni	0.50	0.90
Mo		0.20
V		0.050
Nb		0.050
Cu	0.30	0.50



Product Data Sheet

OK 73.08

E 'Manual metal-arc welding'
ESAB Perstorp AB Sweden

Prepared by A-C Thorsson	Qualified by Tero Borg	Approved by J-P Ernoult	Reg no EN007253	Cancelling EN007076	Reg date 2016-05-17	Page 2 (2)
-----------------------------	---------------------------	----------------------------	--------------------	------------------------	------------------------	---------------

MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO			AWS
	As welded Min	Max	Typ	As welded Min
Rp0.2 (MPa)	460		520	460
Rm (MPa)	530	680	610	550
A4 (%)			30	19
A5 (%)	22			
Charpy V at -50°C (J)	47		100	
	Comments: EN standard requires A5 min 20%.			Comments:

ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 350	80	115	2.6	125	0.62	66.0	0.90	59	21	1,2,3,4,6
3.2 x 350	100	150	3.7	119	0.62	43	1.2	68	23	1,2,3,4,6
3.2 x 450	100	150	4.9	120	0.66	30.5	1.30	90	22	1,2,3,4,6
4.0 x 450	130	200	7.3	120	0.68	20.0	1.80	100	23	1,2,3,4,6
5.0 x 450	190	280	10.6	115	0.70	13.5	2.60	106	27	1,2,3,4

- W** = Weight (kg / 100 electrodes)
η = Efficiency (g weld metal x 100 / g core wire)
N = Effective value (kg weld metal / kg electrodes)
B = Changes (number of electrodes / kg weld metal)
H = Deposit rate at 90% of max current (kg weld metal / hour arc time)
T = Fusion time at 90% of max current (s / electrode)
U = Arc voltage (V)