



Product Data Sheet

OK 74.86 TENSITRODE

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 EN007062	Cancelling EN006776	Reg date 2016-02-15	Page 1 (2)
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REASON FOR ISSUE

Typical mechanical values added.

GENERAL

A basic coated electrode for steels and castings with U.T.S of min 690 N/mm².

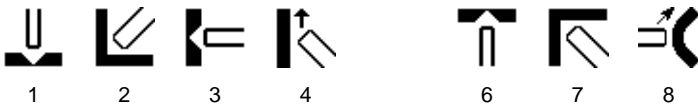
Min AC OCV: 65

Alloy Type: 1.8%Mn, 0.4%Mo

Polarity: AC, DC+

Coating Type: Basic

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.5 E10018-D2
 EN ISO 18275-A E 62 4 Mn1NiMo B T 32 H5

APPROVALS

CE EN 13479
 NAKS/HAKC 3.2-4.0 mm

APPROVALS (SPECIFIC)

Seproz UNA 272580

APPROVAL COMMENT

NAKS/HAKC: Valid for lot numbers starting with SB

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.05	0.10
Si	0.30	0.75
Mn	1.65	2.00
P		0.025
S		0.020
Cr		0.10
Ni	0.6	0.9
Mo	0.3	0.5
V		0.049
Nb		0.049
Cu		0.10

MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO			AWS
	Min	Max	Typ	Min
	Stress relieved 590°C 1h			Stress relieved 620°C 1h
Rp0.2 (MPa)	620		630	600
Rm (MPa)	690	890	720	690
A4 (%)				16
A5 (%)	18		25	
Charpy V at -40°C (J)	47		75	
Charpy V at -50°C (J)			60	27



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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	75	100	2.36	120.6	0.61	69.4	0.86	60.1	21.6	1,2,3,4,6,7,8
3.2 x 450	110	140	4.4	111	0.65	35	1.2	85.6	22	1,2,3,4,6,7,8
4.0 x 450	150	190	7.2	114.3	0.62	22.4	1.72	93.4	22.8	1,2,3,4,6,7,8
5.0 x 450	190	260	10.2	113.5	0.68	14.3	2.72	92.6	22.8	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)