

OK 76.35

Basic DC electrode for welding heat resisting CrMo steel plate or tubes of the type 5 % Cr and 0.5 % Mo.

Specifications

Classifications	SFA/AWS A5.5 : E8015-B6 H4 R EN ISO 3580-A : E CrMo5 B 4 2 H5
Approvals	NAKS/HAKC : 2.5-4.0 mm

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+-
Diffusible Hydrogen	< 4.0 ml/100g
Alloy Type	Low alloyed (5 % Cr ; 0.5 % Mo)
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
PWHT 1 hour(s) 750 °C	500 MPa	620 MPa	22 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
PWHT	20 °C	110 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.05	0.7	0.4	0.03	5	0.55

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.0 x 300.0 mm	50-70 A	23 V	57 %	53 sec	0.49 kg/h
2.5 x 300.0 mm	65-95 A	23 V	57 %	63 sec	0.7 kg/h
3.2 x 350.0 mm	90-130 A	24 V	56 %	70 sec	1.0 kg/h
4.0 x 450.0 mm	125-165 A	24 V	58 %	80 sec	1.3 kg/h