

OK 76.98

OK 76.98 is a low-hydrogen electrode for welding of modified 9 Cr-steels like T91/P91. The electrode is suitable for all-positional welding in pipes and plates.

Specifications	
Classifications	SFA/AWS A5.5 : E9015-B91 (nearest) EN ISO 3580-A : E CrMo91 B 4 2 H5
Approvals	CE : EN 13479 NAKS/HAKC : 2.5-4.0 mm VdTÜV : 07687

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 (9 % Cr, 1 % Mo + Ni / V / Nb)
Coating Type	Basic covering

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
PWHT 2 hour(s) 755 °C	720 MPa	820 MPa	21 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
PWHT	20 °C	50 J

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	V	Nb
0.1	0.8	0.35	0.7	9	1	0.24	0.06

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	70-100 A	21 V	66 %	56 sec	0.9 kg/h
3.2 x 350.0 mm	90-135 A	22 V	60 %	68 sec	1.2 kg/h
4.0 x 450.0 mm	130-200 A	23 V	64 %	85 sec	1.9 kg/h
5.0 x 450.0 mm	140-260 A	22 V	65 %	110 sec	2.3 kg/h