

OK 76.26

Basic AC/DC electrode for welding creep-resisting steels of the type 2.25 % Cr/ 1 % Mo. The weld metal has low impurity levels requested in step-cooling requirements.

Specifications	
Classifications	SFA/AWS A5.5 : E9018-B3 EN ISO 3580-A : E CrMo2 B 32 H5
Approvals	CE : EN 13479 NAKS/HAKC : 2.5-5.0 mm VdTÜV : 10732

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

Welding Current	AC, DC+
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	Low alloyed (2.25 % Cr ; 1.1 % Mo)
Coating Type	Basic covering

Tensile Properties		
Testing Condition	Yield Strength	Tensile Strength
ISO		
Stress Relieved 1 hour(s) 690 °C	650 MPa	740 MPa

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
PWHT	-20 °C	60 J

Typical Weld Metal Analysis %			
C	Mn	Si	Cr
0.07	0.69	0.23	2.17

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 350.0 mm	60-85 A	21 V	63 %	68 sec	0.76 kg/h
3.2 x 350.0 mm	90-130 A	23 V	60 %	66 sec	1.11 kg/h
4.0 x 450.0 mm	130-190 A	25 V	61 %	83 sec	1.9 kg/h
5.0 x 450.0 mm	150-260 A	27 V	62 %	92 sec	2.6 kg/h