

OK 76.28

Basic DC electrode for welding creep-resisting steels of the type 2.25 % Cr and 1 % Mo.

Specifications	
Classifications	SFA/AWS A5.5 : E9018-B3 EN ISO 3580-A : E CrMo2 B 4 2 H5
Approvals	BV : C2M1 H5 CE : EN 13479 NAKS/HAKC : 2.5-4.0 mm VdTÜV : 00971

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

Welding Current	DC+(-)
Diffusible Hydrogen	< 5ml/100g
Alloy Type	Low alloyed (2.2 % Cr ; 1,1 % Mo)
Coating Type	Basic covering

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
PWHT 1 hour(s) 690 °C	630 MPa	720 MPa	21 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
PWHT	20 °C	130 J

Typical Weld Metal Analysis %				
C	Mn	Si	Cr	Mo
0.06	0.7	0.3	2.2	1.1

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.0 x 300.0 mm	55-80 A	23 V	58 %	40 sec	0.7 kg/h
2.5 x 300.0 mm	70-110 A	25 V	58 %	52 sec	0.8 kg/h
3.2 x 350.0 mm	95-150 A	26 V	59 %	62 sec	1.2 kg/h
4.0 x 450.0 mm	130-190 A	28 V	64 %	88 sec	1.8 kg/h
5.0 x 450.0 mm	150-260 A	29 V	64 %	92 sec	2.7 kg/h
6.0 x 450.0 mm	200-350 A	30 V	64 %	90 sec	3.9 kg/h