

OK 76.16

Basic DC low hydrogen electrode for welding creep resisting steels of the type 1.25 % Cr 0.5 % Mo.

Specifications	
Classifications	SFA/AWS A5.5 : E8018-B2-H4R EN ISO 3580-A : E CrMo1B 4 2 H5
Approvals	CE : EN 13479 NAKS/HAKC : 2.5-5.0 mm VdTÜV : 10731

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 (1.25 % Cr ; 0.5 % Mo)
Coating Type	Basic covering

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
AWS			
PWHT 1 hour(s) 690 °C	550 MPa	620 MPa	22 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
AWS		
PWHT	-20 °C	70 J

Typical Weld Metal Analysis %			
C	Mn	Si	Mo
0.06	0.7	0.3	0.5

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	70-110 A	22.7 V	60 %	75 sec	0.65 kg/h
3.2 x 350.0 mm	95-150 A	22.5 V	59 %	71 sec	1.07 kg/h
4.0 x 350.0 mm	130-190 A	22.1 V	89 %	78 sec	1.55 kg/h
5.0 x 450.0 mm	150-260 A	23.6 V	66 %	102 sec	2.49 kg/h