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 UKCA : EN 13479 VdTÜV : 00971

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

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 1 hour(s) 690 °C	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**
2.5 x 300 mm	70-110 A	25 V	58 %	52 sec	0.8 kg/h
3.2 x 350 mm	95-150 A	26 V	59 %	62 sec	1.2 kg/h
4.0 x 450 mm	130-190 A	28 V	64 %	88 sec	1.8 kg/h
5.0 x 450 mm	150-260 A	29 V	64 %	92 sec	2.7 kg/h
6.0 x 450 mm	200-350 A	30 V	64 %	90 sec	3.9 kg/h