OK 76.96



OK 76.96 is an LMA electrode containing 9Cr 1Mo for the welding of creep-resistant steels . It is especially suitable for pipe welding. The electrode runs with a quiet , stable arc and give a minimum amount of spatter. A preheating and interpass temperature of 150-269 C is normally required .

Specifications	
Classifications	SFA/AWS A5.5 : E8015-B8 EN ISO 3580-A : E (CrMo9) B 4 2 H5

Welding Current	DC+
Diffusible Hydrogen	<5ml/100g
Alloy Type	Creep resisting
Coating Type	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
Stress Relieved 2 hour(s) 650 °C	730 MPa	850 MPa	17 %
Stress Relieved 2 hour(s) 750 °C	550 MPa	720 MPa	22 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
Stress Relieved 2 hour(s) 750 °C	20 °C	60 J
Stress Relieved 2 hour(s) 850 °C	20 °C	80 J
Stress Relieved 2 hour(s) 650 °C	20 °C	25 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Cu	Nb
0.07	0.8	0.4	0.02	8.8	1.05	0.03	0.003

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300 mm	70-100 A	25 V	55 %	51 sec	0.8 kg/h
3.2 x 350 mm	90-135 A	26 V	55 %	70 sec	1.1 kg/h
4.0 x 450 mm	130-200 A	21 V	64 %	80 sec	1.9 kg/h