OK 76.98



OK 76.98 is a low-hydrogen electrode for welding of modified 9 Cr-steels like T91/P91. The electrode is suitable for all-positional welding in pipes and plates.

Specifications	
Classifications	SFA/AWS A5.5 : E9015-B91 (nearest) EN ISO 3580-A : E CrMo91 B 4 2 H5
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 07687

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

Welding Current	DC+
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	Low alloyed (9 % Cr, 1 % Mo + Ni / V / Nb)
Coating Type	Basic covering

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
PWHT 2 hour(s) 755 °C	720 MPa	820 MPa	21 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
PWHT 2 hour(s) 755 °C	20 °C	50 J

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**V**	**Nb**
0.1	0.8	0.35	0.7	9	1	0.24	0.06

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
2.5 x 350 mm	70-100 A	21 V	66 %	56 sec	0.9 kg/h
3.2 x 350 mm	90-135 A	22 V	60 %	68 sec	1.2 kg/h
4.0 x 450 mm	130-200 A	23 V	64 %	85 sec	1.9 kg/h
5.0 x 450 mm	140-260 A	22 V	65 %	110 sec	2.3 kg/h