

## OK 76.26



Basic AC/DC electrode for welding creep-resisting steels of the type 2.25 % Cr / 1 % Mo. The weld metal has low impurity levels requested in step-cooling requirements.

Specifications	
<b>Classifications</b>	SFA/AWS A5.5 : E9018-B3 EN ISO 3580-A : E CrMo2 B 32 H5
<b>Approvals</b>	CE : EN 13479 NAKS/HAKC : 2.5-5.0 mm VdTÜV : 10732

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

<b>Welding Current</b>	AC, DC+
<b>Diffusible Hydrogen</b>	< 5.0 ml/100g
<b>Alloy Type</b>	Low alloyed (2.25 % Cr ; 1.1 % Mo)
<b>Coating Type</b>	Basic covering
<b>Min AC OCV</b>	65

Typical Tensile Properties		
Condition	Yield Strength	Tensile Strength
<b>ISO</b>		
Stress Relieved 1 hour(s) 690 °C	650 MPa	740 MPa

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
<b>ISO</b>		
PWHT 1 hour(s) 690 °C	-20 °C	60 J

Typical Weld Metal Analysis %			
C	Mn	Si	Cr
0.07	0.69	0.23	2.17

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm	60-85 A	21 V	63 %	68 sec	0.76 kg/h
3.2 x 350 mm	90-130 A	23 V	60 %	66 sec	1.11 kg/h
4.0 x 450 mm	130-190 A	25 V	61 %	83 sec	1.9 kg/h
5.0 x 450 mm	150-260 A	27 V	62 %	92 sec	2.6 kg/h