

# OK 76.26



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

<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 VdTUV 10732 Sepro UN A 272580

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 (2.2 % Cr ; 1.1 % Mo)
<b>Coating Type</b>	Basic covering

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
PWHT 4hr 690°C	520 MPa	610 MPa	21 %
<b>AWS</b>			
Stress Relieved	490 MPa	580 MPa	24 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>AWS</b>		
Stress Relieved 32hr 690°C	-20 °C	120 J
<b>ISO</b>		
PWHT 4hr 690°C	20 °C	170 J
PWHT 4hr 690°C	-20 °C	140 J

## Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
0.07	0.69	0.23	2.17	1.10

## Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 350.0 mm	60-85 A	21 V	70	68 sec	63 %	0.76 kg/h
3.2 x 350.0 mm	90-130 A	23 V	49	66 sec	60 %	1.11 kg/h
4.0 x 450.0 mm	130-190 A	25 V	23	83 sec	61 %	1.9 kg/h
5.0 x 450.0 mm	150-260 A	27 V	15	92 sec	62 %	2.6 kg/h