

## OK 76.28M

OK 76.28M is a Cr-Mo alloyed electrode for welding of creep resistant steels like P22 / T22 with low carbon. The electrode is suitable for all positional welding of plates & pipes.

### Specifications

|                        |                                                   |
|------------------------|---------------------------------------------------|
| <b>Classifications</b> | SFA/AWS A5.5 : E8018-B3L<br>IS 1395 : E63BB3L26Fe |
|------------------------|---------------------------------------------------|

|                            |               |
|----------------------------|---------------|
| <b>Welding Current</b>     | AC, DC+       |
| <b>Diffusible Hydrogen</b> | < 5 ml/100g   |
| <b>Alloy Type</b>          | Cr-Mo alloyed |
| <b>Coating Type</b>        | Lime Basic    |

### Typical Tensile Properties

| Condition       | Conditional Statement | Yield Strength | Tensile Strength | Elongation |
|-----------------|-----------------------|----------------|------------------|------------|
| Stress Relieved | PWHT 690°C 1h         | 560 MPa        | 650 MPa          | 23 %       |

### Typical Weld Metal Analysis %

| C    | Mn   | Si   | S     | P     | Cr   | Mo   |
|------|------|------|-------|-------|------|------|
| 0.04 | 0.85 | 0.50 | 0.015 | 0.025 | 2.15 | 1.10 |

### Deposition Data

| Diameter        | Current   |
|-----------------|-----------|
| 2.5 x 350.0 mm  | 60-90 A   |
| 3.15 x 450.0 mm | 80-140 A  |
| 4.0 x 450.0 mm  | 100-180 A |