

OK 76.26

Basic low-hydrogen electrode for the AC/DC welding of creep-resistant steels of the 2.3% Cr/1% Mo type, such as SA - 387 Grade 22/A 335 Grade P22 or similar. The weld metal has the extra-low impurity levels specified in step-cooling requirements.

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

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

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

Typical Tensile Properties				
Condition	Conditional Statement	Yield Strength	Tensile Strength	Elongation
ISO				
Stress Relieved	PWHT 690°C 1h	650 MPa	740 MPa	19 %
Stress Relieved	PWHT 690°C 4h	520 MPa	610 MPa	21 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
Stress Relieved	20 °C	170 J
Stress Relieved	-20 °C	140 J
Stress Relieved	-20 °C	60 J

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

Deposition Data	
Diameter	Current
2.5 x 350 mm	60-85 A
3.2 x 350 mm	90-130 A
4.0 x 450 mm	130-190 A
5.0 x 450 mm	150-260 A