

OK 76.28L

OK 76.28L is a basic coated hydrogen controlled iron powder type electrode, depositing a weld metal of the type 2.25Cr-1Mo, suitable for welding of similar Cr-Mo steels, used in high temperature components of power plants, boilers, oil-refineries, petrochemical plants etc. The slag system is designed to give a stable arc and minimum spatter. The weld metal provides scaling resistance up to 600°C.

Specifications	
Classifications	SFA/AWS A5.5 : E9018-B3 EN ISO 3580-A : E CrMo2 B 4 2 H5 IS 1395 : E63BB324Fe
Approvals	CE : EN 13479 IBR : E9018-B3 PDIL : E9018-B3

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

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

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
AWS			
PWHT 2 hour(s) 690 °C	590 MPa	680 MPa	23 %
ISO			
PWHT 1 hour(s) 690 °C	560 MPa	660 MPa	19 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS		
PWHT	20 °C	110 J
ISO		
PWHT	20 °C	130 J

Typical Weld Metal Analysis %								
C	Mn	Si	S	P	Ni	Cr	Mo	V
0.06	0.75	0.35	0.015	0.023	0.05	2.35	1.00	0.02

Deposition Data	
Diameter	Current
2.5 x 350.0 mm	60-90 A
3.15 x 450.0 mm	90-150 A
4.0 x 450.0 mm	120-180 A
5.0 x 450.0 mm	140-270 A