

OK 76.16

Basic DC low hydrogen electrode for welding creep resisting steels of the type 1.25 % Cr 0.5 % Mo.

Specifications	
Classifications	SFA/AWS A5.5 : E8018-B2-H4R EN ISO 3580-A : E CrMo1B 4 2 H5
Approvals	CE : EN 13479 NAKS/HAKC VdTÜV : 10731 Seproz : UNA 272580

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

Welding Current	DC+(-)
Diffusible Hydrogen	< 4.0 ml/100g
Alloy Type	Low alloyed (1.25 % Cr ; 0.5 % Mo)
Coating Type	Basic covering

Typical Tensile Properties				
Condition	Conditional Statement	Yield Strength	Tensile Strength	Elongation
AWS				
Stress Relieved 22 hour(s) 690 °C	Stress relieved	520 MPa	600 MPa	28 %
ISO				
Stress Relieved 2 hour(s) 690 °C	Stress relieved	560 MPa	640 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS		
Stress Relieved	-20 °C	175 J
Stress Relieved	-30 °C	150 J
ISO		
Stress Relieved	20 °C	150 J
Stress Relieved	-20 °C	120 J
Stress Relieved	-30 °C	95 J

Typical Weld Metal Analysis %			
C	Mn	Si	Mo
0.06	0.7	0.3	0.5

Deposition Data	
Diameter	Current
2.5 x 350 mm	70-110 A
3.2 x 350 mm	95-150 A
4.0 x 350 mm	130-190 A
5.0 x 450 mm	150-260 A