

OK 76.18L

OK 76.18L is a basic coated, hydrogen controlled iron powder type electrode, for welding creep resistant steels of 1.25Cr-0.5Mo or similar type, 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. OK 76.18L welds without short-circuiting and deposits a weld metal resistant to both cracking and porosity. The weld metal is resistant to scaling up to 575°C.

Specifications	
Classifications	SFA/AWS A5.5 : E8018-B2 EN ISO 3580-B : E5518-1CM H5 IS 1395 : E55BB224Fe
Approvals	CE : EN 13479 IBR : E8018-B2 PDIL : E8018-B2

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

Welding Current	AC, DC+-
Diffusible Hydrogen	< 4 ml/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	500 MPa	600 MPa	26 %
ISO			
PWHT 1 hour(s) 690 °C	540 MPa	620 MPa	20 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS		
PWHT	20 °C	120 J
PWHT	-20 °C	60 J
ISO		
PWHT	20 °C	170 J

Typical Weld Metal Analysis %						
C	Mn	Si	S	P	Cr	Mo
0.054	0.67	0.34	0.020	0.017	1.30	0.54

Deposition Data	
Diameter	Current
2.5 x 350.0 mm	70-100 A
3.15 x 450.0 mm	90-150 A
4.0 x 450.0 mm	140-180 A
5.0 x 450.0 mm	180-240 A