

# OK 76.18



Basic DC electrode for welding creep resisting steels of the type 1% Cr 0.5% Mo. Welds with a stable arc and minimum spatter. Deposits weld metal resistant to both cracking and porosity.

<b>Classifications</b>	SFA/AWS A5.5 : E8018-B2 EN ISO 3580-A : E CrMo1 B 4 2 H5
<b>Approvals</b>	ABS SR H5 BV Welding of low alloy steels type 1%Cr 0.5%Mo H5 CE EN 13479 DNV-GL -H5 NAKS/HAKC 2.5-4.0 mm VdTUV 01387

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

<b>Welding Current</b>	DC+(-)
<b>Diffusible Hydrogen</b>	< 5ml/100g
<b>Alloy Type</b>	Low alloyed (1.25 % Cr ; 0.5 % Mo)
<b>Coating Type</b>	Basic covering

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
PWHT 1hr 690°C	580 MPa	670 MPa	24 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
PWHT 1hr 690°C	20 °C	100 J

## Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
0.06	0.7	0.3	1.3	0.5

## Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
2.0 x 300.0 mm	55-80 A	22 V	136.0	40 sec	58 %	0.7 kg/h
2.5 x 300.0 mm	70-110 A	24 V	88.0	52 sec	58 %	0.8 kg/h
3.2 x 350.0 mm	95-150 A	25 V	49.0	65 sec	59 %	1.1 kg/h
4.0 x 450.0 mm	130-190 A	27 V	23.0	90 sec	64 %	1.7 kg/h
5.0 x 450.0 mm	150-260 A	28 V	14.5	95 sec	64 %	2.7 kg/h