

OK 76.98



OK 76.98 is a low-hydrogen electrode for welding of modified 9 Cr-steels like T91/P91. The electrode is suitable for all-positional welding in pipes and plates.

Classifications	SFA/AWS A5.5 : E9015-B91 (nearest) EN ISO 3580-A : E CrMo91 B 4 2 H5
Approvals	CE EN 13479 NAKS/HAKC 2.5-4.0 mm VdTUV 07687 Sepro UN A 272580

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

Welding Current	DC+
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	Low alloyed (9 % Cr, 1 % Mo + Ni / V / Nb)
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
PWHT 2hr 755°C	720 MPa	820 MPa	21 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
PWHT 2hr 755°C	20 °C	50 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	V	Nb
0.1	0.8	0.35	0.7	9	1	0.24	0.06

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
2.5 x 350.0 mm	70-100 A	21 V	71.4	56 sec	66 %	0.9 kg/h
3.2 x 350.0 mm	90-135 A	22 V	45.5	68 sec	60 %	1.2 kg/h
4.0 x 450.0 mm	130-200 A	23 V	22.6	85 sec	64 %	1.9 kg/h
5.0 x 450.0 mm	140-260 A	22 V	14	110 sec	65 %	2.3 kg/h