



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 IS 1395 : E63BB324Fe
Approvals	IBR : E9018-B3 PDIL : E9018-B3

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

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation	Testing Temperature	Testing Time
AWS					
PWHT	590 MPa (86 ksi)	680 MPa (99 ksi)	23 %	690 ? (1274 ?)	2 hour(s)

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value	Test Condition Time	Test Condition Temp
AWS				
PWHT	20 ? (68 ?)	110 J (81 ft-lb)	2 hour(s)	690 ? (1274 ?)

Typical Weld Metal Analysis %

C	Si	Mn	P	S	Cr	Ni	Mo	V
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Typical Weld Metal Analysis %

0.06 %	0.35 %	0.75 %	0.023 %	0.015 %	2.35 %	0.05 %	1.00 %	0.02 %
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Deposition Data**Deposition Rate @ 90% I max****Diameter****Current**

0.0 kg/h (0.0 lbs/h)

5.0 x 450.0 mm (0.197 x 17.7 in.)

140-270 A

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Recommended Welding Parameters**Current****Voltage**