



OK 76.35



OK 76.35 is an LMA electrode containing 5Cr0.5Mo for welding creep-resistant steels. It is especially suitable for pipe welding. The electrode runs with a quiet, stable arc and gives a minimum amount of spatter loss. A preheating and interpass temperature of 150-260°C is normally required. The mechanical properties stated here are after one hour of heat treatment at 740°C.

Classifications:	SFA/AWS A5.5:E8015-B6, EN ISO 3580-A:E CrMo5 4 2 H5
Approvals:	Seproz UNA 272580, NAKS/HAKC 2.5-4.0 mm

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

Welding Current:	DC+-
Diffusible Hydrogen:	< 5.0 ml/100g
Alloy Type:	Creep resisting
Coating Type:	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
PWHT 750°C 1h	500 MPa	620 MPa	22 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
PWHT 750°C 1h	20 °C	110 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.05	0.7	0.4	0.03	5	0.55

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.0 x 300 mm	50-70 A	23 V	0.57	139	53 s	0.49 kg/h
2.5 x 300 mm	65-95 A	23 V	0.57	76.9	63 s	0.7 kg/h
3.2 x 350 mm	90-130 A	24 V	0.56	50.0	70 s	1.0 kg/h
4.0 x 450 mm	125-165 A	24 V	0.58	33.3	80 s	1.3 kg/h