

OK 76.96

Type Basic

SMAW

E8015-B8

Description

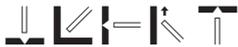
OK 76.96 is an LMA electrode containing 9Cr1Mo for the welding of creep-resistant steels. It is especially suitable for pipe welding. The electrode runs with a quiet, stable arc and gives a minimum amount of spatter. A preheating and interpass temperature of 150-260°C is normally required. The mechanical properties stated here are after one hour of heat treatment at 740°C.

Recovery

115%

Welding current

DC(+)



Classifications

SFA/AWS A5.5	E8015-B8
EN 1599	E CrMo9 B 42 H5

Typical all weld metal composition, %

C	Si	Mn	Cr	Mo
0.05	0.5	0.8	9.5	1.0

Typical mech. properties all weld metal

	740°C/1h
Yield stress, MPa	>460
Tensile strength, MPa	>550
Elongation, %	>20

Charpy V

Test temps, °C	Impact values, J
+20	>80

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.0	300	55-75	23	0.58	131.0	0.5	49
2.5	300	70-100	25	0.55	92.0	0.8	51
3.2	350	90-135	26	0.55	50.0	1.1	70
4.0	450	130-200	21	0.64	22.5	1.9	80
5.0	450	160-270	25	0.64	14.5	2.7	92