

OK 76.96

Type Basic

SMAW

E8015-B8

Description

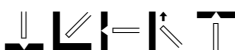
OK 76.96 is an LMA electrode containing 9Cr1Mo for the welding of creep-resistant steels. It is especially suitable for pipe welding. The electrode runs with a quiet, stable arc and gives a minimum amount of spatter. A preheating and interpass temperature of 150-260°C is normally required. The mechanical 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 |