

OK 76.35

Type Lime basic

SMAW

E8015-B6

Description

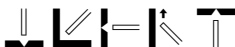
OK 76.35 is an LMA electrode containing 5Cr0.5Mo for welding creep-resistant steels. It is especially suitable for pipe welding. The electrode runs with a quiet, stable arc and gives a minimum amount of spatter loss. A preheating and interpass temperature of 150-260°C is normally required. The mechanical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

Recovery

115%

Welding current

DC(+ -)



Classifications

SFA/AWS A5.5 E8015-B6
EN 1599 E CrMo5 B 42 H5

Typical all weld metal composition, %

C	Si	Mn	Cr	Mo
0.08	0.4	0.8	5.0	0.6

Typical mech. properties all weld metal

	740°C/1h
Yield stress, MPa	>460
Tensile strength, MPa	>550
Elongation, %	>19

Charpy V

Test temps, °C	Impact values, J
+20	>47

Approvals

Sepros UNA 485155

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	50-70	23	0.57	139.0	0.49	53
2.5	300	65-95	23	0.57	76.9	0.7	63
3.2	350	90-130	24	0.56	50.0	1.0	70
4.0	450	125-165	24	0.58	33.3	1.3	80
5.0	450	190-220	24	0.59	16.9	2.2	98