

# OK 76.98

SMAW

Type Basic

E9015-B9 (nearest)

## Description

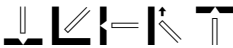
OK 76.98 is a low-hydrogen electrode for welding modified 9 Cr steels like T91/P91. The electrode is suitable for all-positional welding in pipes and plates. The mechanical properties stated here are after two hours of heat treatment at 750°C.

## Recovery

115 %

## Welding current

DC+



## Classifications

SFA/AWS 5.5-96 E9015-B9 (nearest)  
EN 1599 ECrMo 91 B 42 H5

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	N	V	Nb
0.1	0.4	0.7	9.0	0.7	1.0	0.05	0.2	0.06

## Typical mech. properties all weld metal

Yield stress, MPa 650  
Tensile strength, MPa 760  
Elongation, % 18

## Charpy V

Test temps, °C Impact values, J  
+20 70  
0 50

## Approvals

UDT EN 1599  
VdTÜV 07687

## 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
2.5	350	70-100	21	0.66	71.4	0.9	56
3.2	350	90-135	22	0.6	45.5	1.2	68
4.0	450	130-200	23	0.64	22.6	1.9	85