OK 76.18



Basic DC electrode for welding creep resisting steels of the type 1% Cr 0.5% Mo. Welds with a stable arc and minimum spatter. Deposits weld metal resistant to both cracking and porosity.

Specifications	
Classifications	SFA/AWS A5.5 : E8018-B2 EN ISO 3580-A : E CrMo1 B 4 2 H5
Approvals	ABS : 3Y H5 BV : Welding of low alloy steels type 1%Cr 0.5%Mo, H5 CE : EN 13479 DNV-GL : -H5 UKCA : EN 13479 VdTÜV : 01387

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

Welding Current	DC+(-)
Diffusible Hydrogen	< 5ml/100g
Alloy Type	Low alloyed (1.25 % Cr ; 0.5 % Mo)
Coating Type	Basic covering

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
PWHT 1 hour(s) 690 °C	580 MPa	670 MPa	24 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
PWHT 1 hour(s) 690 °C	20 °C	100 J

Typical Weld Metal Analysis %				
C	**Mn**	**Si**	**Cr**	**Mo**
0.06	0.7	0.3	1.3	0.5

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
2.0 x 300 mm	55-80 A	22 V	58 %	40 sec	0.7 kg/h
2.5 x 300 mm	70-110 A	24 V	58 %	52 sec	0.8 kg/h
3.2 x 350 mm	95-150 A	25 V	59 %	65 sec	1.1 kg/h
4.0 x 450 mm	130-190 A	27 V	64 %	90 sec	1.7 kg/h
5.0 x 450 mm	150-260 A	28 V	64 %	95 sec	2.7 kg/h