

OK 76.18



OK 76.18 is an LMA electrode for welding creep-resistant steels of the 1.Cr0.5Mo type. The electrode welds with a quiet, stable arc and produces a minimum of spatter loss. OK 76.18 deposits a weld metal which is resistant to cracking as well as porosity. The scaling temperature of the weld metal is about 575°C.

Classifications:	SFA/AWS A5.5:E8018-B2, EN ISO 3580-A:E CrMo1 B 4 2 H5
Approvals:	CE EN 13479, VdTÜV 01387, NAKS/HAKC 2.5-4.0 mm, ABS SR H5, BV Welding of low alloy steels type 1%Cr 0.5%Mo, H5, DNV -H5

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

Welding Current:	DC+(-)
Diffusible Hydrogen:	< 5ml/100g
Alloy Type:	Creep resisting
Coating Type:	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
PWHT 690°C 1h	580 MPa	670 MPa	24 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
PWHT 690°C 1h	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	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.0 x 300 mm	55-80 A	22 V	0.58	136.0	40 s	0.70 kg/h
2.5 x 300 mm	70-110 A	24 V	0.58	88.0	52 s	0.80 kg/h
3.2 x 350 mm	95-150 A	25 V	0.59	49.0	65 s	1.10 kg/h
4.0 x 450 mm	130-190 A	27 V	0.64	23.0	90 s	1.70 kg/h
5.0 x 450 mm	150-260 A	28 V	0.64	14.5	95 s	2.70 kg/h