OK 76.35

Basic DC electrode for welding heat resisting CrMo steel plate or tubes of the type AISI 502, W.No 7362.

Classifications	SFA/AWS A5.5 : E8015-B6 EN ISO 3580-A : E CrMo5 4 2 H5
Approvals	NAKS/HAKC : 2.5-4.0 mm Seproz : UNA 272580

Welding Current	DC+-
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	Low alloyed (5 % Cr ; 0.5 % Mo)
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
PWHT 1 hour(s) 750 °C (1382 °F)	500 MPa (73 ksi)	620 MPa (90 ksi)	22 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
PWHT 1 hour(s) 750 °C (1382 °F)	20 °C (68 °F)	110 J (81 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.05	0.7	0.4	0.03	5	0.55

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.0 x 300.0 mm (5/64 x 11.8 in.)	50-70 A	23 V	57 %	139	53 sec	0.49 kg/h (1.1 lbs/h)
2.5 x 300.0 mm (0.098 x 11.8 in.)	65-95 A	23 V	57 %	76.9	63 sec	0.7 kg/h (1.5 lbs/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	90-130 A	24 V	56 %	50.0	70 sec	1.0 kg/h (2.2 lbs/h)
4.0 x 450.0 mm (5/32 x 17.7 in.)	125-165 A	24 V	58 %	33.3	80 sec	1.3 kg/h (2.9 lbs/h)

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