

OK 76.28



A basic AC/DC low alloy electrode for MMAW of 2.25 Cr, 1 Mo type steels



Classification AWS A5.5: E 9018-B3
DIN 8575: E Kb Cr Mo 2 26
IS 1395: 63 BB 3 26 Fe

DESCRIPTION

OK 76.28 is a basic, medium-heavy coated, hydrogen controlled iron powder type, all position electrode depositing a weldmetal of the type 2.25% Cr, 1% Mo steels suitable for welding of similar Cr-Mo steels. The slag system design allows excellent stable arc characteristics in all positions with minimum spatter providing smooth and even bead. The weldmetal provides scaling resistance upto 600°C and is radiographically sound.

APPROVALS: PDIL, IBR

WELDING CURRENT: DC±, AC 65V

TYPICAL APPLICATIONS

OK 76.28 finds extensive use in fabrication of low alloy steel boilers and piping operating at temperature upto 600°C in oil refineries, thermal and chemical plants, preheater, super heaters, steam boilers and especially for hydro-crackers.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties		Hot Tensile Properties*	
C	0.08	S	0.018	YS	550 N/mm ²	400°C	480 N/mm ²
Mn	0.70	Cr	2.30	UTS	650 N/mm ²	500°C	445 N/mm ²
Si	0.35	Mo	1.00	EL (L=4d)	22%	550°C	415 N/mm ²
P	0.018					600°C	360 N/mm ²

* Annealed 1H at 700°C, furnace cooled.

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	70-110	130	520
3.15	450	90-150	95	380
4.00	450	130-190	60	240
5.00	450	150-260	35	140

PACKING: Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box.