



Product Data Sheet

OK 75.78

E 'Manual metal-arc welding'
ESAB Perstorp AB Sweden

Prepared by P-O Oskarsson	Qualified by Tero Tolonen	Approved by J-P Ernoult	Reg no EN006780	Cancelling EN006562	Reg date 2015-07-23	Page 1 (2)
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REASON FOR ISSUE

General information.

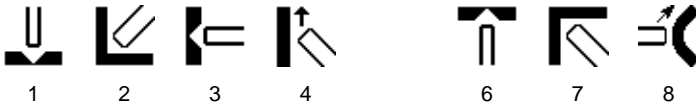
GENERAL

This electrode is tailored for steels with very high tensile strength. The electrode gives tensile strength over 900 N/mm² and impact values over 47 J at -60 °C.

Min AC OCV: 65
Polarity: AC, DC+

Alloy Type: CrNiMo
Coating Type: Basic
Diff Hydrogen: <5.0 ml/100g

WELDING POSITIONS



CLASSIFICATIONS Electrode

EN ISO 18275-A E 89 6 Z B 32 H5

APPROVALS

Seproz UNA 272580

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.030	0.060
Si	0.15	0.50
Mn	1.75	2.40
P		0.015
S		0.015
Cr	0.40	0.60
Ni	2.60	3.40
Mo	0.55	0.65

MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO
	As welded Typ
Rp0.2 (MPa)	922
Rm (MPa)	974
A4-A5 (%)	19
Charpy V at -60°C (J)	47



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ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 350	70	110	2.2	115	0.61	73.5	0.9	52	24	1,2,3,4,6,7,8
3.2 x 350	110	150	4.8	115	0.63	32.6	1.4	77	24	1,2,3,4,6,7,8
4.0 x 450	150	200	7.1	115	0.65	21.9	1.9	86	24	1,2,3,4,6,7,8

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)