Product Data Sheet

OK 76.26

E 'Manual metal-arc welding'
ESAB AB Sweden

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
P-O Oskarsson	Christos Skodras	Karin Ivarsson	EN005598	EN005180	2011-11-04	1 (2)

REASON FOR ISSUE

CE approval update

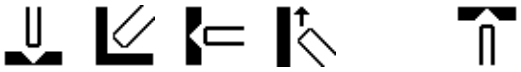
GENERAL

Basic AC/DC electrode for welding creep-resisting steels of the type 2.3% Cr/ 1% Mo. The weld metal has extra low impurity levels requested in step-cooling requirements.

Min AC OCV: 65
Polarity: AC, DC+

Alloy Type: Cr-Mo
Coating Type: Lime Basic
Diff Hydrogen: <5.0 ml/100g

WELDING POSITIONS



1 2 3 4 6

CLASSIFICATIONS Electrode

SFA/AWS A5.5	E9018-B3
EN ISO 3580-A	E CrMo2 B 32 H5

APPROVALS

CE	EN 13479
VdTÜV	10732

APPROVALS (SPECIFIC)

Seproz	UNA 272580

CHEMICAL COMPOSITION

	All Weld Metal (%)	
	Min	**Max**
C	0.05	0.10
Si	0.10	0.50
Mn	0.40	0.90
P		0.010
S		0.010
Cr	2.05	2.45
Ni		0.1
Mo	0.90	1.20
V		0.03
Nb		0.009
Cu		0.1
Sn		0.010
As		0.007
Sb		0.005

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MECHANICAL PROPERTIES OF WELD METAL

	ISO		AWS
	PWHT 690°C 1h		PWHT 690°C 1h
Properties	**Min**	**Typ**	**Min**
Rp0.2 (MPa)			530
ReL (MPa)	400	650	
Rm (MPa)	500	740	620
A4 (%)			17
A5 (%)	18		
Charpy V at 20°C (J)	47		
Charpy V at -20°C (J)		60	

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U	Welding
Ø x Length	Min	Max								Positions
2.5 x 350	60	85	2.2	120	0.63	70	0.76	68	21	1,2,3,4,6
3.2 x 350	90	130	3.4	104	0.60	49	1.11	66	23	1,2,3,4,6
4.0 x 450	130	190	7.0	110	0.61	23	1.90	83	25	1,2,3,4,6
5.0 x 450	150	260	10.9	110	0.62	15	2.60	92	27	1,2,3,4

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)

OTHER DATA

X-factor according to:
(10P + 5Sb + 4Sn + As) x10000 /100 = < 15 ppm

Si + Mn <1.1%