

OK 76.18G



A rutile AC/DC low alloy electrode for MMAW



Classification AWS A5.5: E 8013-G
IS 1395: E55RG124

DESCRIPTION

OK 76.18G is a rutile-coated electrode depositing a 1.0 Cr/0.45 Mo/0.25 V type low alloy deposit for high temperature service up to 550°C. OK 76.18G is specially designed for joining plant piping and are of radiographic quality.

WELDING CURRENT: DC +, AC 70 V

TYPICAL APPLICATIONS

OK 76.18G are suitable for low alloy steel boiler and piping applications that are operated at elevated temperatures of up to 550°C. OK 76.18G. It can also be used for fabrication of boiler heads and spares of similar composition that find usage at petro-chemical, refineries, thermal power plants etc.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.07	Cr	1.05	YS	500 N/mm ²
Mn	0.5	Mo	0.50	UTS	580 N/mm ²
Si	0.25	S	0.02	EL (L=4d)	22%
P	0.02				
V	0.30				

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.