

# OK 76.18 M

## A basic AC/DC low alloy electrode for MMAW

Classification    AWS A5.5: E 7018-B2L  
 IS 1395: E 49 BB 2 L 26 Fe



### DESCRIPTION

OK 76.18 M is a basic coated, low Carbon, hydrogen controlled iron powder type electrode used for welding creep resistant steels of 1.25% Chromium, 0.5% Molybdenum type. The slag system design is such that the electrode welds with a quite, stable arc and gives a minimum amount of spatter and a weld bead that is smooth and even. OK 76.18 M welds without short-circuiting and deposits a weldmetal resistant to both cracking and porosity. Root runs can be made easily with the electrode. The weldmetal is resistant to scaling upto 575°C and of radiographic quality.

**WELDING CURRENT:** DC±, AC 50V

### TYPICAL APPLICATIONS

OK 76.18 M is specially used for welding of 1.25 Cr 0.5 Mo and similar creep resistant steels which find extensive use in high temperature components of power plants, boilers, oil- refineries, petrochemical plants, boilers etc. Steels of the type ASTM A 182-F2, F11, F12, A387-2, 11, 12, A213-T2, T11, T12, A335- P2, P11, P12 and German steels 13 Cr Mo 44, 15 Cr Mo 5 etc.

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	<0.05	Mo	0.55	YS	510 N/mm <sup>2</sup>
Mn	0.60	Cr	1.40	UTS	600 N/mm <sup>2</sup>
Si	0.35			EL (L=4d)	24%

### 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.