



# Product Data Sheet

# OK 76.35

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

Prepared by P-O Oskarsson	Qualified by Tero Borg	Approved by J-P Ernoult	Reg no EN007105	Cancelling EN006728	Reg date 2016-02-23	Page 1 (2)
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## REASON FOR ISSUE

Typical mechanical values amended.

## GENERAL

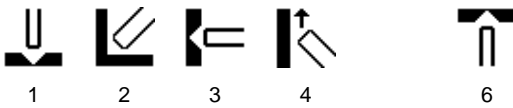
Basic DC electrode for welding heat resisting CrMo steel plate or tubes of the type AISI 502, W.No 7362.

**Polarity:** DC+-

**Alloy Type:** Creep resisting

**Coating Type:** Lime Basic

## WELDING POSITIONS



## CLASSIFICATIONS Electrode

SFA/AWS A5.5      E8015-B6  
 EN ISO 3580-A    E CrMo5 4 2 H5

## APPROVALS

NAKS/HAKC      2.5-4.0 mm  
 Seproz            UNA 272580

## APPROVAL COMMENT

NAKS/HAKC: Valid for lot numbers starting with SB

## CHEMICAL COMPOSITION

### All Weld Metal (%)

	Min	Max
C	0.05	0.10
Si	0.2	0.5
Mn	0.6	1.0
P		0.015
S		0.015
Cr	4.0	6.0
Ni		0.1
Mo	0.45	0.65
Nb		0.009
Cu		0.10
Sn		0.02
Pb		0.01
As		0.01
Sb		0.01

## MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO		AWS
	Min	Typ	Min
	PWHT 750°C 1h		PWHT 740°C 1h
Rp0.2 (MPa)	400	500	460
Rm (MPa)	590	620	550
A4 (%)			19
A5 (%)	17	22	
Charpy V at 20°C (J)	47	110	



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## ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	$\eta$	N	B	H	T	U	Welding Positions
	Min	Max								
2.0 x 300	50	70	1.3	112	0.57	139	0.49	53	23	1,2,3,4,6
2.5 x 300	65	95	2.3	105	0.57	76.9	0.7	63	23	1,2,3,4,6
3.2 x 350	90	130	3.6	105	0.56	50.0	1.0	70	24	1,2,3,4,6
4.0 x 450	125	165	5.2	105	0.58	33.3	1.3	80	24	1,2,3,4,6

**W** = Weight (kg / 100 electrodes)

**$\eta$**  = 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)