

PRODUCT DATA SHEET

Afrox 76S



Afrox 76S is a basic coated hydrogen controlled CMnNi (normally 0,8% Ni) electrode developed for the offshore and other demanding areas of fabrication. It is capable of excellent impact results in the root area of welds at temperatures down to -50°C. High CTOD values in heavy joints are obtained without need for excessive back gouging, stress relieving or low temperature heat treatment. In common with other Afrox electrodes for offshore and other demanding structural work, Afrox 76S has the extra security of a low moisture content coating and high resistance to moisture re-absorption.

Classifications

AWS	A5.5	E7018-G
EN	2560-A	E 42 6 INi B H5

Typical Chemical Analysis

% Carbon	0,035 - 0,075	% Silicon	0,2 - 0,4
% Manganese	1,4 - 1,8	% Sulphur	0025 max
% Nickel	0,7 - 1,0	% Phosphorous	0,025 max

Typical Mechanical Properties (All weld metal in the as welded condition)

Tensile Strength	520 - 640 MPa
0,2% Proof Strength	420 MPa
% Elongation on 5d	28
Charpy V-Notch at -30°C	120 J
Charpy V-Notch at -60°C	60 J

Packing Data

(DC+ AC 70 OCV min DC- for root runs)

Diameter (mm)	Current (A)	Pack Mass (kg)	Item Number
2,5	70 - 100	3 x 4,0	W075242
3,15	80 - 130	3 x 4,0	W075243
4,0	120 - 180	3 x 4,0	W075244

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