

# OK 48.00



A reliable, general purpose electrode for manual metal arc welding of carbon steels, carbon manganese steels and fine-grained carbon manganese steels with elevated yield strength. OK 48.00 deposits a tough, crack-resistant weld metal. The coating is of the low moisture absorption type. High welding speed in the vertical-up position. OK 48.00 is insensitive to the composition of the base material within fairly wide limits. The electrode can be used for welding structures where difficult stress conditions cannot be avoided.

<b>Beteckning</b>	SFA/AWS A5.1: E7018 H4 R EN ISO 2560-A: E 42 4 B 42 H5
<b>Godkännanden</b>	ABS 3Y H5 BV 3Y H5 CE EN 13479 DB 10.039.12 DNV-GL 3 YH5 LR 3Ym H5 PRS 3Y H5 RINA 3Y H5 RS 3Y H5 VdTUV 00690 NAKS/HAKC 2.0-5.0 mm
<b>Bransch eller segment</b>	Civil Construction Energy Industrial and General Fabrication Marine and Offshore Light Fabrication

Godkännanden baseras på fabriken lokaliserings. Vänligen kontakta ESAB för mer information.

<b>Welding Current</b>	DC+(-)
<b>Diffusible Hydrogen</b>	< 4.0 ml/100g
<b>Alloy Type</b>	Carbon Manganese
<b>Coating Type</b>	Basic covering

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	475 MPa	565 MPa	29 %
<b>AWS</b>			

### Slagseghetsdata Charpy V

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As Welded	-30 °C	130 J
As Welded	-40 °C	115 J
<b>AWS</b>		
As Welded	-30 °C	130 J

### Typical Wire Composition %

C	Mn	Si
0.06	1.1	0.5

### Insmätningsdata

Diameter	Ampere	Volt	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Insmätningshastighet
1.6 x 300 mm	30-55 A	24 V	0.59	192	50 sec	0.38 kg/h
2.0 x 300 mm	55-80 A	22 V	0.65	125	45 sec	0.63 kg/h
2.5 x 350 mm	70-110 A	24 V	0.67	65	57 sec	0.96 kg/h
3.2 x 350 mm	90-140 A	23 V	0.70	42	68 sec	1.24 kg/h
3.2 x 450 mm	90-140 A	23 V	0.73	31	85 sec	1.33 kg/h
4.0 x 350 mm	120-190 A	24 V	0.70	29	75 sec	1.63 kg/h
4.0 x 450 mm	120-190 A	24 V	0.71	22	92 sec	1.76 kg/h
5.0 x 450 mm	190-260 A	24 V	0.75	13	99 sec	2.61 kg/h
6.0 x 450 mm	220-340 A	26 V	0.80	9	97 sec	3.88 kg/h
7.0 x 450 mm	280-410 A	27 V	0.79	7.0	104 sec	4.83 kg/h