

OK 45.40

User friendly rutile electrode for steel construction and welding of sheet steel. Excellent bead appearance.

Specifications	
Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E38 0 R 12
Approvals	CE : EN 13479 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+-
Alloy Type	Carbon Manganese
Coating Type	Rutile covering

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.0 x 300.0 mm	50-80 A	25 V	60 %	38 sec	0.55 kg/h
2.5 x 300.0 mm	70-110 A	25 V	54 %	42 sec	0.8 kg/h
3.2 x 350.0 mm	80-150 A	26 V	57 %	57 sec	1.3 kg/h
3.2 x 450.0 mm	80-140 A	26 V	54 %	74 sec	1.3 kg/h