

OK 48.08

Basic universal electrode with very good welding characteristics, especially designed for welding of carbon steels, carbon manganese steels and fine grained carbon manganese steels with elevated yield strength. Typical field of application is offshore construction. The weld metal alloyed with approximately 0.9% Ni fulfills the requirements on impact toughness at -50°C. The coating is of low moisture absorption type and gives diffusible hydrogen < 4ml per 100 grams of weld metal. OK 48.08 is HIC test compliant as per NACE TM0284 & SSC test compliant as per NACE TM0177.

Specificaties	
Classificaties	SFA/AWS A5.5 : E7018-G H4R EN ISO 2560-A : E 46 5 1Ni B 32 H5
Goedkeuringen	ABS : 3Y H5 CE : EN 13479 DB : 10.039.31 DNV-GL : 4 Y40H5 LR : 4Y40 H5 NAKS/HAKC : 2.5-5.0 mm RS : 4Y H5 VdTÜV : 05778

Goedkeuringen zijn gebaseerd op fabriekslocatie. Neem contact op met ESAB voor meer informatie.

Lasstroom	AC, DC+(-)
Diffundeerbaar waterstof	< 4.0 ml/100g
Legering Type	Low alloyed (0.9 % Ni)
Coating Type	Basic covering

Typische Mechanische Eigenschappen			
Conditionering	Rek grens	Treksterkte	Rek
AWS			
Zoals gelast (3G, V-UP)	530 MPa	610 MPa	
ISO			
PWHT 1 hour(s) 620 °C	480 MPa	550 MPa	26 %
Zoals gelast	540 MPa	630 MPa	26 %

Kerfslageigenschappen		
Conditionering	Testtemperatuur	Kerfslagwaarde
AWS		
Zoals gelast (3G, V-UP)	-60 °C	50 J
Zoals gelast (3G, V-UP)	-50 °C	55 J
ISO		
Zoals gelast	-60 °C	65 J
PWHT	-46 °C	105 J
Zoals gelast	-50 °C	85 J

Typische lasmetaalanalyse (%)					
C	Mn	Si	Ni	Cr	Mo
0.06	1.2	0.35	0.95	0.02	0.001

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Neersmeltgegevens					
Diameter	Ampère	Volt	Rendement (%)	Smelttijd per elektrode bij 90% I max	Neersmelt
2.5 x 350.0 mm	65-110 A	20 V	60 %	57 sec	0.9 kg/h
3.2 x 350.0 mm	85-150 A	22 V	63 %	63 sec	1.3 kg/h
3.2 x 450.0 mm	85-150 A	22 V	63 %	64 sec	1.3 kg/h
4.0 x 450.0 mm	115-190 A	25 V	66 %	95 sec	1.8 kg/h
5.0 x 450.0 mm	155-280 A	28 V	66 %	93 sec	2.7 kg/h