

OK 43.32

Easy-to-weld rutile type electrode for welding in the flat position. The good flowing properties of the weld metal give a good finish of the weld beads both on butt and fillet welds. Good slag detachability. The stable arc, also on low welding currents, makes the electrode very suitable for sheet metal welding.

Specifications	
Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 42 0 RR 12
Approvals	ABS : 2 BV : 2 CE : EN 13479 DB : 10.039.36 DNV : 2 LR : 2 UKCA : EN 13479 VdTÜV : 00621

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

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

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	460 MPa	520 MPa	27 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	0 °C	60 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.08	0.5	0.4

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	23 V	54 %	36 sec	0.6 kg/h
2.5 x 350.0 mm	50-110 A	25 V	54 %	46 sec	0.9 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
4.0 x 350.0 mm	120-210 A	25 V	52 %	63 sec	1.6 kg/h
4.0 x 450.0 mm	120-210 A	27 V	54 %	76 sec	1.9 kg/h
5.0 x 450.0 mm	170-290 A	26 V	56 %	87 sec	2.5 kg/h
6.0 x 450.0 mm	230-370 A	31 V	52 %	105 sec	2.8 kg/h