

OK 48.18

OK 48.18 is a general purpose, LMA electrode for mild and low-alloy steels. Allround electrode with good impact values.

Specifications

Classifications	SFA/AWS A5.1 : E7018-1
	EN ISO 2560 : E 42 4 B 32

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	490 MPa	575 MPa	29 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-20 °C	160 J
As Welded	-40 °C	>47 J
As Welded	-50 °C	90 J

Deposition Data

Diameter	Current	Voltage	Efficiency (%)
3.2 mm	110-150 A	21 V	125 %
4 mm	150-200 A	22 V	125 %
4.5 mm	150-240 A	22 V	125 %
5 mm	190-260 A	23 V	125 %