

OK 50.40

OK 50.40 is an all-round electrode for positional welding mild steel, also well suited for pipe welding. It is particularly good for welding in the vertical upward position and for welding root beads.

Specifications	
Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 42 2 RB 12
Approvals	CE : EN 13479 DB : 10.039.14 DNV : 2 LR : 2 VdTÜV : 00629

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

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

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	470 MPa	540 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	-20 °C	75 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.07	0.5	0.2

Deposition Data						
Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	50-100 A	23 V	80 %	88.0	51 sec	0.8 kg/h
3.2 x 350.0 mm	80-150 A	24 V	55 %	59	53 sec	1.15 kg/h
4.0 x 450.0 mm	130-190 A	22 V	150 %	27.0	90 sec	1.5 kg/h
5.0 x 450.0 mm	170-280 A	27.2 V	58 %	17.2	92.3 sec	2.26 kg/h