

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

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

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	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	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
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