OK 53.05

OK 53.05 is a low-hydrogen electrode with especially good running characteristics and very good mechanical properties. Because of its double coating, it produces a deep crater, which stabilises the arc and gives good protection in inclined positions.

Specifications	
Classifications	SFA/AWS A5.1 : E7016 EN ISO 2560-A : E 42 4 B 22 H10
Approvals	ABS : 3Y CE : EN 13479 DB : 10.039.32 DNV : 3Y H10 LR : 3Y H10 UKCA : EN 13479 VdTÜV : 03180

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

Welding Current	DC+-
Alloy Type	Carbon Manganese
Coating Type	Basic covering

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	470 MPa	540 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	-40 °C	80 J

Typical Weld Metal Analysis %		
C	**Mn**	**Si**
0.06	0.96	0.54

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 350.0 mm	50-100 A	24 V	63 %	49 sec	1.0 kg/h
3.2 x 350.0 mm	80-140 A	26 V	60 %	57 sec	1.2 kg/h
3.2 x 450.0 mm	80-140 A	26 V	61 %	70 sec	1.3 kg/h
4.0 x 350.0 mm	110-180 A	25 V	63 %	60 sec	1.8 kg/h