

## OK 46.44

Rutile cellulosic electrode particularly suitable for vertical-down welding. Good ability to bridge gaps.

| Specifications  |                                                                                                               |
|-----------------|---------------------------------------------------------------------------------------------------------------|
| Classifications | SFA/AWS A5.1 : E6013<br>EN ISO 2560-A : E 38 0 RC 11                                                          |
| Approvals       | ABS : 2<br>BV : 2<br>CE : EN 13479<br>DB : 10.039.01<br>DNV : 2<br>LR : 2<br>UKCA : EN 13479<br>VdTÜV : 00674 |

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

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

| Typical Tensile Properties |                |                  |            |
|----------------------------|----------------|------------------|------------|
| Condition                  | Yield Strength | Tensile Strength | Elongation |
| ISO                        |                |                  |            |
| As Welded                  | 460 MPa        | 530 MPa          | 26 %       |

| Typical Charpy V-Notch Properties |                     |              |
|-----------------------------------|---------------------|--------------|
| Condition                         | Testing Temperature | Impact Value |
| ISO                               |                     |              |
| As Welded                         | 0 °C                | 60 J         |

| Typical Weld Metal Analysis % |     |     |
|-------------------------------|-----|-----|
| C                             | Mn  | Si  |
| 0.07                          | 0.5 | 0.4 |

| Deposition Data |           |         |                |                                        |                 |
|-----------------|-----------|---------|----------------|----------------------------------------|-----------------|
| Diameter        | Current   | Voltage | Efficiency (%) | Fusion time per electrode at 90% I max | Deposition Rate |
| 2.5 x 350.0 mm  | 70-100 A  | 26 V    | 61 %           | 58 sec                                 | 0.78 kg/h       |
| 3.2 x 350.0 mm  | 90-150 A  | 30 V    | 51 %           | 52 sec                                 | 1.0 kg/h        |
| 4.0 x 350.0 mm  | 110-200 A | 22 V    | 62 %           | 62 sec                                 | 1.58 kg/h       |