

OK 46.64

Rutil cellulosic electrode for welding in all positions including vertical down. Well suited for repair welding and other applications where the good ability to bridge gaps is of advantage. Intensive to rust, primer and zinc coatings.

Specifications	
Classifications	SFA/AWS A5.1 : E6012 EN ISO 2560-A : E 38 0 RC 11
Approvals	ABS : 2 BV : 2 CE : EN 13479 DB : 10.039.08 DNV : 2 GL : 2 LR : 2 RS : 2 VdTUV : 01579

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

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

Typical Tensile Properties		
Yield Strength	Tensile Strength	Elongation
AWS		
ISO		

Typical Charpy V-Notch Properties	
Condition	Testing Temperature
ISO	
As Welded	-10 °C

Deposition Data						
Diameter	Current	Voltage	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm	50-100 A	24 V	0.62	91	51 sec	0.8 kg/h
3.2 x 350 mm	80-140 A	22 V	0.61	58	58 sec	1.1 kg/h
4.0 x 350 mm	120-200 A	21 V	0.59	38	66 sec	1.4 kg/h
5.0 x 350 mm	160-260 A	23 V	0.62	25	61 sec	2.3 kg/h