

OK 48.04

AC/DC, general purpose, LMA electrode for welding mild and low alloy steels. It has very good welding properties and deposits a high quality weld metal with good mechanical properties. The electrode can be used for welding restrained structures where high stresses cannot be avoided.

Specifications	
Classifications	SFA/AWS A5.1 : E7018 EN ISO 2560-A : E 42 4 B 32 H5
Approvals	ABS : E7018 ABS : 3Y H5 BV : 3Y H5 CE : EN 13479 DNV-GL : 3 YH5 LR : 3Y H15 PRS : 3Y H5 UKCA : EN 13479 VdTÜV : 00050

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

Welding Current	AC, DC+(-)
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	480 MPa	560 MPa	28 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-40 °C	100 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.07	1.12	0.35

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 350.0 mm	75-110 A	23 V	64 %	59 sec	1.0 kg/h
3.2 x 350.0 mm	90-155 A	22 V	63 %	62.4 sec	1.37 kg/h
3.2 x 450.0 mm	90-155 A	25 V	67 %	92 sec	1.5 kg/h
4.0 x 450.0 mm	125-200 A	26 V	68 %	101 sec	2.0 kg/h
5.0 x 450.0 mm	190-260 A	26 V	72 %	106 sec	2.8 kg/h