

OK 53.35

OK 53.35 is our most efficient electrode for vertical welding, specifically designed for welding vertically downwards. Welding vertically downwards with OK 53.35 is done with a relatively large diameter electrode and a high current, thus giving a high welding speed.

Specifications	
Classifications	SFA/AWS A5.1 : E7048 EN ISO 2560-A : E 42 4 B 31 H5
Approvals	ABS : 3Y H5 BV : 3Y H5 CE : EN 13479 DB : 10.039.33 DNV : 3Y H5 GL : 3Y H5 PRS : 3Y H5 RS : 3Y H5 VdTÜV : 00631

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	Lime Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	460 MPa	560 MPa	30 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	-20 °C	140 J
As Welded	-40 °C	90 J
As Welded	-30 °C	110 J

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
3.2 x 450 mm	80-150 A	24 V	0.65	38	69 sec	1.37 kg/h
4.0 x 450 mm	110-200 A	27 V	0.70	25.0	69 sec	2.20 kg/h
4.5 x 450 mm	150-230 A	25 V	0.64	20	89 sec	2 kg/h
5.0 x 450 mm	170-280 A	28 V	0.68	16.0	77 sec	2.90 kg/h