

OK 48.05

General-purpose basic DC electrode for mild and low alloyed steels. Very good running characteristics especially on DC+. Good running even at low currents which, for instance, is an advantage in welding of thin walled pipes. The coating is of Low Moisture Absorption type.

Specifications	
Classifications	SFA/AWS A5.1 : E7018 EN ISO 2560-A : E 42 4 B 42 H5
Approvals	ABS : 3Y H5 CE : EN 13479 DB : 10.039.02 DNV-GL : 3 YH5 UKCA : EN 13479 VdTÜV : 06610

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

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

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	445 MPa	540 MPa	29 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	-40 °C	70 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.05	1.0	0.7

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.0 x 300.0 mm	35-80 A	22 V	63 %	50 sec	0.6 kg/h
2.5 x 350.0 mm	75-105 A	24 V	64 %	58 sec	1.0 kg/h
3.2 x 350.0 mm	95-155 A	26 V	46 %	61 sec	1.5 kg/h
3.2 x 450.0 mm	95-155 A	26 V	61 %	80 sec	1.5 kg/h
4.0 x 450.0 mm	125-210 A	24 V	67 %	85 sec	2.1 kg/h