

OK 53.04

OK 53.04 offers tough crack resistant welds in mild and low-alloyed steels.

Specifications	
Classifications	SFA/AWS A5.1 : E7016 EN ISO 2560-A : E 42 4B 12 H5
Approvals	ABS : 3YH5 BKI : 3 Y H15 DNV : 3YH10 GL : 3YH10 LR : 3Y H15

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

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	500 MPa	590 MPa	27 %

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

Deposition Data						
Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	70-110 A	23 V	56 %	81.0	50 sec	0.9 kg/h
3.2 x 350.0 mm	90-140 A	23 V	60 %	48.0	62 sec	1.2 kg/h
4.0 x 350.0 mm	120-190 A	23 V	61 %	33	66 sec	1.7 kg/h
5.0 x 400.0 mm	150-240 A					0.0 kg/h