

OK 48.15

General purpose basic AC, DC+(-) low hydrogen electrode for welding of carbon steels and carbon manganese steels. Very good running characteristics especially on AC.

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 DB : 10.039.06 DNV-GL : 3 YH5 LR : 3Y H5 PRS : 3Y H5 UKCA : EN 13479 VdTÜV : 00625

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

Welding Current	AC, DC+(-)
Diffusible Hydrogen	< 5 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering

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

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	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	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	75-110 A	23 V	64 %	59 sec	1.0 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