OK 53.68

A high quality LMA electrode, particularly suitable for on site welding. The electrode yields a homogeneous , high quality weld metal with extra low content of impurities. It operates well on AC as well as DC positive and negative. DC negative is preferred , as it produces a small easily controlled weld pool, minimising the risk of burn through or undercutting. The electrode is CTOD tested.

Specifications	
Classifications	SFA/AWS A5.1 : E7016-1 H4 R EN ISO 2560-A : E 42 5 B 12 H5
Approvals	ABS : 3Y H5 BV : 3Y H5 CE : EN 13479 DNV-GL : 4 YH5 PRS : 3Y H5 VdTÜV : 06807

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

Welding Current	AC, DC+(-)
Diffusible Hydrogen	< 4.0 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	470 MPa	550 MPa	30 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	-50 °C	140 J
As Welded	-45 °C	150 J

Typical Weld Metal Analysis %		
C	**Mn**	**Si**
0.06	1.2	0.4

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 350.0 mm	55-85 A	22 V	58 %	50 sec	0.8 kg/h
3.2 x 450.0 mm	80-130 A	22 V	61 %	73 sec	1.2 kg/h
4.0 x 450.0 mm	110-170 A	22 V	65 %	83 sec	1.7 kg/h