

OK 48.50

General purpose AC and DC+(-) basic electrode for mild and low alloy steels. The running characteristics are very good. It is a Low Moisture Absorption (LMA) type coating.

Specifications	
Classifications	SFA/AWS A5.1 : E7018-1 H4R EN ISO 2560-A : E 42 4 B 32 H5
Approvals	ABS : 3Y H5 BV : 3Y H5 CE : EN 13479 DNV : 3Y H5 LR : 3Y H5 RINA : 3Y H5 UKCA : EN 13479 VdTÜV : 11813

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

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	500 MPa	570 MPa	28 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-40 °C	70 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.07	1.09	0.49

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.0 x 300.0 mm	55-90 A	22 V	65 %	45 sec	0.63 kg/h
2.5 x 300.0 mm	70-110 A	23 V	60 %	53 sec	0.8 kg/h
2.5 x 350.0 mm	70-110 A	22 V	63 %	63 sec	0.8 kg/h
3.2 x 450.0 mm	100-150 A	23 V	64 %	92 sec	1.2 kg/h
4.0 x 450.0 mm	130-200 A	22 V	65 %	101 sec	1.6 kg/h
5.0 x 450.0 mm	160-260 A	22 V	68 %	109 sec	2.3 kg/h