

OK 55.00 Tensitrode

A basic coated, low hydrogen electrode for welding mild and higher tensile steels with consistent properties down to -30°C.

Specifications

Classifications	SFA/AWS A5.5-81 : E8018-G
	EN 499 : E50 3 B 32 H 5
	BS 639 : 1986 E51 44B (120 26H)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	>510 MPa	590 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-20 °C	115 J
As Welded	-30 °C	47 J

Deposition Data

Diameter	Current
3.2 mm	110-140 A
4 mm	140-200 A
5 mm	200-270 A
6 mm	215-360 A
2.5 mm	80-110 A