

OK GoldRox

OK GoldRox is a true all-round and all-position rutile electrode. With exceptional arc stability and reduced spatter for decreased cleaning time, start and restart properties that allow for easy tack welds, and brilliant slag removal, novice and experienced welders can rely on OK GoldRox. Available in different package sizes – all fully recyclable – to make sure each pack fits specific job requirements.

Specifications	
Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 42 0 RC 11
Approvals	ABS : 2 BV : 2 CE : EN 13479 DB : 10.039.48 DNV : 2 LR : 2 UKCA : EN 13479 VdTÜV : 19622

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

Welding Current	DC+-, AC
Alloy Type	Carbon Manganese
Coating Type	Rutile-cellulosic covering

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	450 MPa	520 MPa	26 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	0 °C	60 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.07	0.45	0.42

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per l max	Deposition rate at 90Per
2.0 x 300.0 mm	50-70 A	25 V	60 %	38 sec	0.55 kg/h
2.5 x 350.0 mm	60-90 A	25 V	62 %	49 sec	0.8 kg/h
3.2 x 350.0 mm	90-140 A	24 V	59 %	57 sec	1.1 kg/h
4.0 x 350.0 mm	110-185 A	26 V	58 %	64 sec	1.4 kg/h