

OK 46.00

OK 46.00 is an excellent performing, easy to use, rutile electrode and is relatively insensitive to rust or other surface impurities. It deposits smooth weld beads in all positions including vertical down with self releasing slag. Good striking and restriking properties making it ideal for short welds, root runs and tacking, also useful for bridging gaps.

Specifications	
Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 38 0 RC 11
Approvals	ABS : 2 BV : 2 CE : EN 13479 DB : 10.039.05 DNV : 2 LR : 2 UKCA : EN 13479 VdTÜV : 00623

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

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

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	400 MPa	510 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	0 °C	70 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.08	0.42	0.30

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
1.6 x 300.0 mm	30-60 A	26 V	63 %	36 sec	0.38 kg/h
2.0 x 300.0 mm	50-80 A	25 V	60 %	38 sec	0.55 kg/h
2.5 x 350.0 mm	60-100 A	22 V	65 %	50 sec	0.8 kg/h
3.2 x 350.0 mm	80-150 A	22 V	65 %	57 sec	1.3 kg/h
4.0 x 350.0 mm	100-230 A	22 V	60 %	65 sec	1.6 kg/h
4.0 x 450.0 mm	100-230 A	27 V	69 %	71 sec	1.77 kg/h
5.0 x 350.0 mm	150-290 A	24 V	60 %	87 sec	2.3 kg/h
5.0 x 450.0 mm	150-290 A	24 V	60 %	114 sec	2.3 kg/h