

OK 48.04

Lime-basic

SMAW

E7018

Description

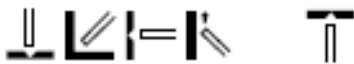
OK 48.04 is an AC/DC, general purpose, LMA electrode for welding mild and low-alloy steels. It has very good welding properties and deposits a high quality weld metal with very good mechanical properties. The electrode can be used for welding restrained structures where high welding stresses cannot be avoided.

Recovery

125%

Welding current

AC, DC+(-) OCV 65V



Packing/Ordering Information

Part Number	Dia mm	Inner Carton	Carton Weight (kg)	Pallet Weight (kg)
3380324N00	3.2	6.0	18.0	972.0
3380404N00	4.0	6.0	18.0	972.0
3380504N00	5.0	6.0	18.0	972.0
33805070C0	5.0	16.0	16.0	1056.0

Classifications

SFA/AWS A5.1	E7018
ISO 2560-A	E 42 4 B 32 H5

Typical all weld metal composition, %

C	Si	Mn
0.06	0.5	1.1

Typical properties of all weld metal

Yield stress, Mpa	480
Tensile strength, MPa	560
Elongation, %	30

Charpy V

Test temps, °C	Impact values, J
-20	150
-40	100

Approvals

ABS	3H5, 3Y
BV	3YHH
DNV	3 YH10
GL	3YH10
LR	3, 3YH15

Welding parameters

Diameter, mm	Length, mm	Welding Current, A	Arc Voltage, V	N.	B.	H.	T.
				Kg Weld Metal/(kg) Electrodes	No. of Electrodes/ (kg) Weld metal	Kg weld Metal/(hour) Arc Time	Burn-off time, (secs)/ Electrode
2.0	300	50-80	23	0.61	125	0.67	44
2.5	350	70-110	23	0.64	67.0	1.0	59
3.2	350	110-150	22	0.63	42.3	1.37	62.4
3.2	450	110-150	25	0.67	30.0	1.5	92
4.0	450	150-200	26	0.68	20.0	2.0	101
5.0	450	190-260	26	0.72	13.0	2.8	105