

# OK 53.04

Basic

SMAW

E7016

## Description

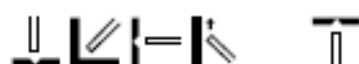
A low-hydrogen electrode with especially good running characteristics and very good mechanical properties. OK 53.04 offers tough crack resistant welds in mild and low-alloyed steels.

## Recovery

105%

## Welding current

DC+, AC



## Packing/Ordering Information

Part Number	Dia mm	Inner Carton	Carton Weight (kg)	Pallet Weight (kg)
5304253NRS	2.5	5.0	20.0	1000.0
5304323NR0	3.2	5.0	20.0	1000.0
5304403NR0	4.0	5.0	20.0	1000.0
530450HNRO	5.0	5.0	20.0	1000.0
VacPac				
5304253NV0	2.5	3.0	12.0	600.0
5304323NV0	3.2	3.3	13.2	620.0
5304403NV0	4.0	3.3	13.2	660.0

## Classifications

AWS A5.1	E 7016
EN 499	E42 4 B 12 H5

## Typical all weld metal composition, %

C	Si	Mn
0.07	0.6	1.0

## Typical properties of all weld metal

Yield stress, Mpa	500
Tensile strength, MPa	590
Elongation, %	27

## Charpy V

Test temps, °C	Impact values, J
-20	150
-40	110

## Approvals

ABS	3Y, 3H5
GL	3Y H10
LR	3M, 3YM, H15
DNV	3Y H10
BKI	3Y H15

## Welding parameters

Diameter, mm	Length, mm	Welding Current, A	Arc Voltage, V	N. Kg Weld Metal/(kg) Electrodes	B. No. of Electrodes/ (kg) Weld metal	H. Kg weld Metal/(hour) Arc Time	T. Burn-off time, (secs)/ Electrode
2.5	350	70-110	24	0.56	81	0.9	50
3.2	350	90-140	25	0.60	48	1.2	62
4.0	350	120-190	26	0.61	33	1.7	66
5.0	400	105-240	26	0.63	18	2.4	87