

OK 55.00

Lime-basic

SMAW

E7018-1

Description

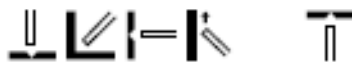
OK 55.00 is a reliable, high-quality, LMA electrode, particularly suitable for welding high strength low-alloy steels. The good, low-temperature impact strength of the weld metal should be noted. The weld metal is also very resistant to hot cracking. The electrode is also suitable for welding high strength ship's steel, grades A, D and E.

Recovery

125%

Welding current

AC, DC+ OCV 65V



Packing/Ordering Information

Part Number	Dia mm	Inner Carton	Carton Weight (kg)	Pallet Weight (kg)
5500253NR0	2.5	5.0	20.0	1000.0
550032HNR0	3.2	5.0	20.0	1000.0
550040HNR0	4.0	5.0	20.0	1000.0
550050HNR0	5.0	5.0	20.0	1000.0
VacPac				
5500253NV0	2.5	3.0	12.0	600.0
550032HNV0	3.2	3.7	14.8	740.0
550040HNV0	4.0	3.7	14.8	740.0
550050HNV0	5.0	4.0	16.0	800.0

Classifications

SFA/AWS A5.1	E7018-1
CSA W48	E4918-1
CSN 05 5010	E 55.93
EN ISO 2560-A	E 46 5 B 32 H5

Typical all weld metal composition, %

C	Si	Mn
0.07	0.5	1.4

Typical properties of all weld metal

Yield stress, Mpa	480
Tensile strength, MPa	590
Elongation, %	28

Charpy V

Test temps, °C	Impact values, J
-20	115
-50	50

Approvals

ABS	3H5, 3Y H5
BV	3Y H5
DNV	4Y H5
LR	3M, 3YM, M5

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
2.5	350	80-110	23	0.64	65.8	0.86	64
3.2	350	110-140	23	0.62	41.1	1.22	72
3.2	450	110-140	24	0.69	30.0	1.4	88
4.0	350	140-200	23	0.62	28.0	1.77	72
4.0	450	140-200	24	0.70	19.0	2.0	94
5.0	450	200-270	24	0.72	13.0	3.0	94
6.0	450	215-360	25	0.72	9.0	4.0	98