

OK 48.00

Type Lime-basic

SMAW

E7018

Description

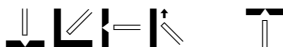
A reliable, general purpose, LMA electrode for mild and low-alloy steels. OK 48.00 deposits a tough, crack-resistant weld metal. High welding speed in the vertical-up position. OK 48.00 is insensitive to the composition of the base material within fairly wide limits. The electrode can be used for welding structures where difficult stress conditions cannot be avoided.

Recovery

125%

Welding current

DC+(-)



Classifications

SFA/AWS A5.1	E7018
CSA W48	E4918
EN 499	E 42 4 B 42 H5
ISO 2560	E51 5B 120 20H

Typical all weld metal composition, %

C	Si	Mn
0.06	0.5	1.2

Typical mech. properties all weld metal

Yield stress, MPa	445
Tensile strength, MPa	540
Elongation, %	29

Charpy V

Test temps, °C	Impact values, J
-20	140
-40	70

Approvals

ABS	3H5, 3Y	RINA	E 52 3 HH
BV	3, 3Y H5	RS	3YHH
CL		Sepros	
CWB	CSA W48	SFS	EN 499
DB	10.039.12	SS	EN 499
DNV	3Y H5	UDT	EN 499
DS	EN 499	Ü	10.039/12
GL	3Y H5	VdTUV	
LR	3,3Y H5		
PRS	3YH10		

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, s/ electrode
1.6	300	30-55	22				
2.0	300	50-80	24				
2.5	350	80-110	23	0.65	62.5	1.0	56
3.2	350	90-140	22	0.64	43	1.3	66
3.2	450	90-140	23	0.64	32.3	1.5	76
4.0	350	125-210	24	0.51	35.0	2.1	64
4.0	450	125-210	26	0.67	20.5	2.1	86
5.0	450	200-260	23	0.69	13.5	2.6	102
6.0	450	220-340	23	0.72	9.6	3.7	102
7.0	450	280-410	25	0.72	7.0	4.4	117