

OK 48.50



General purpose AC and DC+ (-) basic electrode for mild and low alloy steels. The running characteristics are very good. It is a Low Moisture Absorption (LMA) type coating.

Classifications:	SFA/AWS A5.1:E7018-1 H4R, EN ISO 2560-A:E 42 4 B 32 H5
Approvals:	ABS 3Y H5, BV 3YH5, CE EN 13479, DNV 4YH5, GL 4YH5, LR 3YH5, RINA 4YH5, VdTÜV 11813

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

Welding Current:	AC, DC+(-)
Diffusible Hydrogen:	< 4.0 ml/100g
Alloy Type:	Carbon manganese
Coating Type:	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	500 MPa	570 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	-40 °C	70 J
As welded	-45 °C	60 J

Typical Weld Metal Analysis %

C	Mn	Si
0.06	1.2	0.4

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.0 x 300 mm	55-80 A	22 V	0.65 kg	125	45 sec	0.63 kg/h
2.5 x 300 mm	70-110 A	23 V	0.60 kg	81	53 sec	0.8 kg/h
2.5 x 350 mm	70-110 A	22 V	0.63 kg	68	63 sec	0.8 kg/h
3.2 x 350 mm	100-150 A	22 V	0.64 kg	43	66 sec	1.3 kg/h
3.2 x 450 mm	100-150 A	23 V	0.64 kg	33	92 sec	1.2 kg/h
4.0 x 350 mm	130-200 A	-	-	-	-	-
4.0 x 450 mm	130-200 A	22 V	0.65 kg	23	101 sec	1.6 kg/h
5.0 x 450 mm	160-260 A	22 V	0.68 kg	15	109 sec	2.3 kg/h