

OK 46.00

Type Rutile

SMAW

E6013

Description

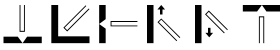
OK 46.00 is the best, all-round, rutile electrode and it is relatively insensitive to rust or other surface impurities. It deposits smooth weld beads in all positions, including vertical down, and the slag is easy to remove. OK 46.00 is very easy to strike and restrike, making it ideal for short welds, root runs and tacking.

Recovery

95%

Welding current

AC,DC+ - OCV 50 V



Classifications

SFA/AWS A5.1	E6013
EN 499	E 38 0 RC 11
ISO 2560	E 43 3 R 11
CSN 05 5010	E 46.17

Typical all weld metal composition, %

C	Si	Mn
0.08	0.3	0.4

Typical mech. properties all weld metal

Yield stress, MPa	400
Tensile strength, MPa	510
Elongation, %	28

Charpy V

Test temps, °C	Impact values, J
0	70
-20	35

Approvals

ABS	2
BV	2
DB	10.039.05
DNV	2
DS	EN 499 E 38 0 RC 11
GL	2
LR	2
PRS	2
RS	2
Sepros	UNA 485154
SS	EN 499 E 38 0 RC 11
UDT	EN 499
Ü	10.039/1
VdTÜV	00623

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	30-60	20	0.63	263	0.38	36
2.0	300	50-70	21	0.60	172	0.55	38
2.5	350	60-100	22	0.65	86.0	0.8	50
3.2	350	80-150	22	0.65	53.0	1.3	57
4.0	350	100-200	22	0.60	39.0	1.6	65
5.0	350	150-290	24	0.60	24.0	2.3	87
5.0	450	170-220	24	0.60	31.0	2.3	114

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