

OK 48.08

Type Lime-basic

SMAW

E7018-G

Description

OK 48.08 is an LMA electrode with very good mechanical properties suitable for demanding applications, such as offshore. The weld metal contains approximately 1% Ni for high impact values down to -40°C. The coating is of the latest LMA type for optimum resistance to porosity and hydrogen cracking. OK 48.08 is CTOD tested.

Recovery

125%

Welding current

AC, DC+(-) OCV 65 V



Classifications

SFA/AWS A5.5	E7018-G
EN 499	E 46 5 1Ni B 32 H5
ISO 2560	E 51 5 B 120 24 H

Typical all weld metal composition, %

C	Si	Mn	Ni
0.06	0.4	1.2	0.8

Typical mech. properties all weld metal

Yield stress, MPa	540
Tensile strength, MPa	600
Elongation, %	26

Charpy V

Test temps, °C	Impact values, J
-20	160
-40	130
-50	100
-60	60

Approvals

ABS	3H5 3Y
CL	EN 499
DB	10.039.31
DNV	4 Y40H5
DS	EN 499
GL	4YH5
LR	4Y40 H15
Sepros	UNA 409819
SS	EN 499
UDT	EN 499
Ü	10.039/1
VdTUV	05778

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
2.0	300	55-80	22	0.57	135.1	0.6	42
2.5	350	75-110	27	0.57	88.2	1.0	41
3.2	350	110-150	22	0.62	42.3	1.3	66
3.2	450	110-150	22	0.66	30.0	1.4	85
4.0	350	150-200	22	0.66	26.5	2.0	68
4.0	450	150-200	22	0.69	20.3	2.0	90
5.0	450	190-275	23	0.69	14.0	3.0	85
6.0	450	220-360	26	0.66	10.0	3.8	95

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