

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

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 90% I max
2,0 x 300 mm	50-80 A	22 V	0.61	125	44 s	0.7 kg/h
2.5 x 300 mm	70-110 A	23 V	0.60	81	53 s	0.8 kg/h
2,5 x 350 mm	70-110 A	22 V	0.63	68	63 s	0.8 kg/h
3,2 x 450 mm	100-150 A	23 V	0.64	33	92 s	1.2 kg/h
4,0 x 450 mm	130-200 A	22 V	0.65	23	101 s	1.6 kg/h
5,0 x 450 mm	160-260 A	22 V	0.68	15	109 s	2.3 kg/h