

OK 48.60



General-purpose basic DC + electrode for mild and low alloy steels. Very good running characteristics.

Classifications	SFA/AWS A5.1: E7018 EN ISO 2560-A: E 42 4 B 42 H5
Approvals	ABS 3Y H5 BV 3Y H5 CE EN 13479 DB 10.039.23 DNV 3 YH5 GL 3YH5 LR 3Y H5 VdTUV 10094

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

Welding Current	DC+
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	445 MPa	540 MPa	28 %
AWS			

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-30 °C	80 J
As Welded	-40 °C	70 J
AWS		
As Welded	-30 °C	-

Typical Weld Metal Analysis %

C	Mn	Si
0.04	1.19	0.64

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
2.5 x 350 mm	70-110 A	24 V	0.67	65	57 sec	0.96 kg/h
3.2 x 350 mm	90-140 A	23 V	0.70	42	68 sec	1.24 kg/h
3.2 x 450 mm	90-140 A	23 V	0.73	31	85 sec	1.33 kg/h
4.0 x 350 mm	120-190 A	24 V	0.70	29	75 sec	1.63 kg/h
4.0 x 450 mm	120-190 A	24 V	0.71	22	92 sec	1.76 kg/h
5.0 x 450 mm	190-260 A	24 V	0.75	13	99 sec	2.61 kg/h