OK 48.00 L



OK 48.00 L is a reliable, high-quality, LMA electrode particularly suitable for welding high strength low-alloy steels. The good, low-temperature impact strength of the weld metal should be noted. The weld metal is also very resistant to hot cracking.

Specifications	
Classifications	SFA/AWS A5.1 : E7018 H4 R EN ISO 2560-A : E 42 5 B 42 H5
Approvals	ABS : 3YH5 BV : 3Y H5 CE : EN 13479 DNV : 3 YH5 UKCA : EN 13479

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

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	500 MPa	580 MPa	30 %
ISO			
As Welded	510 MPa	590 MPa	29 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
AWS		
As Welded	-30 °C	150 J
ISO		
As Welded	-45 °C	115 J
As Welded	-50 °C	105 J

Typical Weld Metal Analysis %		
C	**Mn**	**Si**
0.06	1.5	0.5
0.06	1.5	0.5

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
2.5 x 350 mm	80-110 A	22 V	62 %	62 sec	0.81 kg/h
3.2 x 350 mm	110-140 A	23 V	61 %	70 sec	1.17 kg/h
3.2 x 450 mm	110-140 A	24 V	68 %	86 sec	1.4 kg/h
4.0 x 350 mm	140-200 A	23 V	53 %	69 sec	1.84 kg/h
4.0 x 450 mm	140-200 A	24 V	68 %	86 sec	1.89 kg/h