OK 46.00

OK 46.00 is an excellent performing, easy to use, rutile electrode and is relatively insensitive to rust or other surface impurities.
It deposits smooth weld beads in all positions including vertical down with self releasing slag. Good striking and restriking properties making it ideal for short welds, root runs and tacking, also useful for bridging gaps.

Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 38 0 RC 11 GOST 9467-75 : E46 GOST R ISO 2560-A : E 38 0 RC 11
Approvals	ABS 2 BV 2 CE EN 13479 DB 10.039.05 DNV 2 GL 2 LR 2 RS 2 VdTÜV 00623 BKI 2 ClassNK KMW2 NAKS/HAKC 2.5 3.0 4.0 5.0 mm NAKS/HAKC 3.0-4.0 mm NAKS/HAKC 3.2-4.0 mm RRR 2

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

Welding Current	AC, DC+-
Alloy Type	Carbon Manganese
Coating Type	Rutile-cellulosic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	400 MPa	510 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	0 °C	70 J

Typical Weld Metal Analysis %

C	Mn	Si
0.08	0.42	0.30

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
1.6 x 300.0 mm	30-60 A	26 V	263	36 sec	63 %	0.38 kg/h
2.0 x 300.0 mm	50-70 A	25 V	172	38 sec	60 %	0.55 kg/h
2.5 x 350.0 mm	60-100 A	22 V	86	50 sec	65 %	0.8 kg/h
3.0 x 350.0 mm	70-140 A	32 V	77	46 sec	51 %	1.0 kg/h
3.2 x 350.0 mm	80-150 A	22 V	53	57 sec	65 %	1.3 kg/h
3.2 x 450.0 mm	80-150 A	22 V	43	63 sec	64 %	1.33 kg/h
4.0 x 400.0 mm	100-200 A	26 V	33	64 sec	60 %	1.69 kg/h
4.0 x 450.0 mm	100-200 A	23 V	33	76 sec	58 %	1.94 kg/h
5.0 x 350.0 mm	150-290 A	24 V	24	87 sec	60 %	2.3 kg/h
5.0 x 400.0 mm	150-290 A	30 V	22	71 sec	56 %	2.2 kg/h
5.0 x 450.0 mm	150-290 A	24 V	31	114 sec	60 %	2.3 kg/h

410003-en_WW-FactSheet_Main-01 2022-01-19