

OK 55.00



OK 55.00 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. The electrode is also suitable for welding high strength ships steel, grades A, D and E.

Tested according to NACE TM0177 and TM0284.

Diffusible Hydrogen tested in various conditions show values below 3 ml/100g.

Classifications	SFA/AWS A5.1 : E7018-1H4 R CSA W48 : E4918-1-H4 EN ISO 2560-A : E 46 5 B 32 H5
Approvals	ABS 3Y H5 BV 3Y H5 CE EN 13479 CWB E4918-1-H4 DB 10.039.03 DNV-GL 3Y H5 LR 3Y H5 RS 3Y H5 VdTUV 00632 NAKS/HAKC *5.0mm

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

Welding Current	AC, DC+
Diffusible Hydrogen	< 4.0 ml/100g (< 3 for most of the batches)
Alloy Type	Carbon Manganese
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	500 MPa	590 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-45 °C	105 J
As Welded	-50 °C	100 J

Typical Weld Metal Analysis %

C	Mn	Si
0.06	1.5	0.5

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
2.5 x 350.0 mm	80-110 A	23 V	66	64 sec	64 %	0.9 kg/h
3.2 x 350.0 mm	110-140 A	23 V	41	72 sec	62 %	1.2 kg/h
3.2 x 450.0 mm	110-140 A	24 V	30	88 sec	69 %	1.4 kg/h
4.0 x 350.0 mm	140-200 A	23.2 V	28	72.5 sec	62 %	1.77 kg/h
4.0 x 450.0 mm	140-200 A	24 V	19	94 sec	71 %	2.0 kg/h
5.0 x 450.0 mm	200-270 A	24 V	13	94 sec	72 %	3.0 kg/h
6.0 x 450.0 mm	215-360 A	25 V	9	98 sec	72 %	4.0 kg/h