

OK 45.40



User friendly rutile electrode for steel construction and welding of sheet steel. Excellent bead appearance.

Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E38 0 R 12
Approvals	CE EN 13479

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

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

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
2.0 x 300.0 mm	50-70 A	25 V	172	38 sec	60 %	0.55 kg/h
2.5 x 300.0 mm	70-110 A	25 V	111	42 sec	54 %	0.8 kg/h
2.5 x 350.0 mm	70-110 A	26 V	100	47 sec	50 %	0.8 kg/h
3.2 x 350.0 mm	80-150 A	26 V	51	57 sec	57 %	1.3 kg/h
3.2 x 450.0 mm	80-140 A	26 V	40.5	74 sec	54 %	1.3 kg/h
4.0 x 350.0 mm	120-210 A	25 V	35	63 sec	52 %	1.6 kg/h