

# OK GoldRox



OK GoldRox is a true all-round and all-position rutile electrode. With exceptional arc stability and reduced spatter for decreased cleaning time, start and restart properties that allow for easy tack welds, and brilliant slag removal, novice and experienced welders can rely on OK GoldRox. Available in different package sizes – all fully recyclable – to make sure each pack fits specific job requirements.

<b>Classifications</b>	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 42 0 RC 11
<b>Approvals</b>	ABS 2 BV 2 CE EN 13479 DB 10.039.48 DNV-GL 2 LR 2 VdTUV 19622

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

<b>Welding Current</b>	DC+-, AC
<b>Alloy Type</b>	Carbon Manganese
<b>Coating Type</b>	Rutile-cellulosic covering

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	460 MPa	520 MPa	23 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As Welded	0 °C	60 J

## Typical Weld Metal Analysis %

C	Mn	Si
0.08	0.45	0.40

## 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 350.0 mm	60-90 A	25 V	91	49 sec	62 %	0.8 kg/h
3.0 x 350.0 mm	90-140 A	26 V	65	52 sec	59 %	1.06 kg/h
3.2 x 350.0 mm	90-140 A	24 V	59	57 sec	59 %	1.1 kg/h
4.0 x 350.0 mm	110-185 A	26 V	40	64 sec	58 %	1.4 kg/h