

OK 48.60



General- purpose basic DC + electrode for mild and low alloy steels. Very good running characteristics.

Classifications:	SFA/AWS A5.1:E7018, EN ISO 2560-A:E 42 4 B 42 H5
Approvals:	ABS 3Y H5, BV 3, 3Y H5, CE EN 13479, DB 10.039.23, DNV 3 YH5, GL 3YH5, LR 3Y H5, VdTÜV 10094

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

Welding Current:	DC+
Diffusible Hydrogen:	< 5.0 ml/100g
Alloy Type:	Carbon Manganese
Coating Type:	Basic covering

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	445 MPa	540 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As welded	-30 °C	80 J
As welded	-40 °C	70 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.04	1.19	0.64

Deposition Data						
Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm	70-110 A	24 V	0.67 kg	65	57 sec	0.96 kg/h
3.2 x 350 mm	90-140 A	23 V	0.70 kg	42	68 sec	1.24 kg/h
3.2 x 450 mm	90-140 A	23 V	0.73 kg	31	85 sec	1.33 kg/h
4.0 x 350 mm	120-190 A	24 V	0.70 kg	29	75 sec	1.63 kg/h
4.0 x 450 mm	120-190 A	24 V	0.71 kg	22	92 sec	1.76 kg/h
5.0 x 450 mm	190-260 A	24 V	0.75 kg	13	99 sec	2.61 kg/h