

OK 46.16



OK 46.16 is an all positional, rutile electrode for welding mild steels. It gives less spatter than most other rutile electrodes, the slag is easy to remove and the weld bead is smooth and even. It is easy to strike and restrike and therefore also good for tack welding.

Classifications:	EN ISO 2560-A:E 38 0 RC 11, SFA/AWS A5.1:E7014
Approvals:	CE EN 13479, ABS 2, DNV 2, BV 2, LR 2, GL 2, RS 2, DB 10.039.37, VdTÜV 02528

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

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	440 MPa	510 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	0 °C	60 J

Typical Weld Metal Analysis %

C	Mn	Si
0.09	0.5	0.4

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 90% I max
2.0 x 300 mm	50-70 A	24 V	0.57	167	40 s	0.54 kg/h
2.5 x 350 mm	60-100 A	25 V	0.6	86	49 s	0.9 kg/h
3.2 x 350 mm	80-150 A	23 V	0.58	52	59 s	1.3 kg/h
4.0 x 350 mm	100-200 A	24 V	0.59	34	65 s	1.8 kg/h