

OK 48.00



A reliable, general purpose electrode for manual metal arc welding of carbon steels, carbon manganese steels and fine-grained carbon manganese steels with elevated yield strength. OK 48.00 deposits a tough, crack-resistant weld metal. The coating is of the low moisture absorption type. High welding speed in the vertical-up position. OK 48.00 is insensitive to the composition of the base material within fairly wide limits. The electrode can be used for welding structures where difficult stress conditions cannot be avoided.

Classifications:	EN ISO 2560-A:E 42 4 B 42 H5, SFA/AWS A5.1:E7018 H4 R
Approvals:	CE EN 13479, ABS 3Y H5, PRS 3Y H5, BV 3Y H5, GL 3Y H5, DNV 3Y H5, RS 3Y H5, LR 3Ym H5, DB 10.039.12, VdTÜV 00690, NAKS/HAKC 2.0-5.0 mm

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

Welding Current:	DC+(-)
Diffusible Hydrogen:	< 4.0 ml/100g
Alloy Type:	Carbon-Manganese
Coating Type:	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	475 MPa	565 MPa	29 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As welded	-30 °C	130 J
ISO		
As welded	-30 °C	130 J
As welded	-40 °C	115 J

Typical Weld Metal Analysis %

C	Mn	Si
0.06	1.1	0.5