

OK 48.05



OK 48.05 is a general purpose, LMA electrode for welding mild and low-alloyed steels. It has very good running characteristics, especially on DC+. OK 48.05 welds very well even at very low currents, an advantage when welding thin-walled pipes.

Classifications:	SFA/AWS A5.1:E7018, EN ISO 2560-A:E 42 4 B 42 H5
Approvals:	CE EN 13479, ABS 3Y H5, DB 10.039.02, DNV 3 YH5, Sepron UNA 272580, VdTÜV 06610, LR 3Ym H5

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:	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	445 MPa	540 MPa	29 %

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
0.06	1.1	0.5

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	35-80 A	22 V	0.627	119	50.1 s	0.6 kg/h
2.5 x 350 mm	75-105 A	24 V	0.64	62.5	58 s	1.00 kg/h
3.2 x 350 mm	95-155 A	26 V	0.46	54.3	61 s	1.50 kg/h
3.2 x 450 mm	95-155 A	26 V	0.61	31.3	80 s	1.50 kg/h
4.0 x 450 mm	125-210 A	24 V	0.67	20.5	85 s	2.10 kg/h