

# OK 48.08



OK 48.08 is an LMA electrode with very good mechanical properties suitable for demanding applications, such as offshore. The weld metal contains approximately 1% Ni for high impact values down to -40°C. The coating is of the latest LMA type for optimum resistance to porosity and hydrogen cracking. OK 48.08 is CTOD tested.

<b>Classifications:</b>	SFA/AWS A5.5:E7018-G, EN ISO 2560-A:E 46 5 1Ni B 32 H5
<b>Approvals:</b>	CE EN 13479, ABS 3Y H5, DNV 4Y40 H5, GL 4Y H5, RS 4Y H5, DB 10.039.31, VdTÜV 05778, LR 4Y40m H5, NAKS/HAKC 2.5-5.0 mm

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

<b>Welding Current:</b>	AC, DC +(-)
<b>Diffusible Hydrogen:</b>	<5.0 ml/100g
<b>Alloy Type:</b>	0.9% Ni
<b>Coating Type:</b>	Lime Basic

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As welded	540 MPa	630 MPa	26 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As welded	-50 °C	115 J
As welded	-60 °C	90 J

## Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.06	1.2	0.35	0.95	0.02	0.001

## 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	55-80 A	22 V	0.57	135.1	42 s	0.60 kg/h
2.5 x 350 mm	75-110 A	27 V	0.57	88	41 s	1.0 kg/h
3.2 x 350 mm	110-150 A	22 V	0.62	42.3	66 s	1.30 kg/h
3.2 x 450 mm	110-150 A	22 V	0.66	30.0	85 s	1.40 kg/h
4.0 x 450 mm	150-200 A	22 V	0.69	20.3	90 s	2.00 kg/h
5.0 x 450 mm	190-275 A	23 V	0.69	14.0	85 s	3.00 kg/h