

# OK 50.40



OK 50.40 is an all-round electrode for the positional welding of mild steel, also well suited for pipe welding. It is particularly good for welding in the vertical-up position and for welding root runs.

<b>Classifications:</b>	SFA/AWS A5.1:E6013, EN ISO 2560-A:E 42 2 RB 12
<b>Approvals:</b>	CE EN 13479, DNV 2, LR 2, DB 10.039.14, VdTÜV 00629

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

<b>Welding Current:</b>	AC, DC+/-
<b>Alloy Type:</b>	Carbon Manganese
<b>Coating Type:</b>	Rutile Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	470 MPa	540 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As welded	-20 °C	75 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.07	0.5	0.2

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
2.5 x 350 mm	50-100 A	23 V	0.80	88.0	51 s	0.80 kg/h
3.2 x 350 mm	80-150 A	24 V	0.55	59	53 s	1.15 kg/h
4.0 x 450 mm	130-190 A	22 V	1.50	27.0	90 s	1.50 kg/h
5.0 x 450 mm	170-280 A	27.2 V	0.58	17.2	92.3 s	2.26 kg/h