

OK 48.60



General-purpose basic DC + electrode for mild and low alloy steels. Very good running characteristics.

Classifications:	SFA/AWS A5.1:E7018, EN ISO 2560-A:E 42 4 B 42 H5
Approvals:	CE EN 13479, GL 3YH5, LR 3Y H5, DNV 3 YH5, ABS 3 H5, 3Y, BV 3, 3Y H5, DB 10.039.23, VdTÜV 10094

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	28 %

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
0.04	1.19	0.64

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	70-110 A	24 V	0.67	65	57 s	0.96 kg/h
3.2 x 350 mm	90-140 A	23 V	0.70	42	68 s	1.24 kg/h
3.2 x 450 mm	90-140 A	23 V	0.73	31	85 s	1.33 kg/h
4.0 x 350 mm	120-190 A	24 V	0.70	29	75 s	1.63 kg/h
4.0 x 450 mm	120-190 A	24 V	0.71	22	92 s	1.76 kg/h
5.0 x 450 mm	190-260 A	24 V	0.75	13	99 s	2.61 kg/h