

## OK 46.30



All-round, general purpose rutile electrode for thin and medium thick plates. Good striking and restriking properties, suitable for tack welding. Useful for bridging gaps.

| Specifications  |   |
|-----------------|---|
| Classifications | SFA/AWS A5.1 : E6013<br>EN ISO 2560-A : E 38 0 R 12 |
| Approvals       | CE : EN 13479<br>UKCA : EN 13479                    |

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

|                 |                  |
|-----------------|------------------|
| Welding Current | AC, DC+(-)       |
| Alloy Type      | Carbon Manganese |
| Coating Type    | Rutile covering  |
| Min AC OCV      | 50V              |

| Typical Tensile Properties |                |                  |            |
|----------------------------|----------------|------------------|------------|
| Condition                  | Yield Strength | Tensile Strength | Elongation |
| ISO                        |                |                  |            |
| As Welded                  | 440 MPa        | 515 MPa          | 26 %       |

| Typical Charpy V-Notch Properties |                     |              |
|-----------------------------------|---------------------|--------------|
| Condition                         | Testing Temperature | Impact Value |
| ISO                               |                     |              |
| As Welded                         | 0 °C                | 70 J         |

| Typical Weld Metal Analysis % |      |      |
|-------------------------------|------|------|
| C                             | Mn   | Si   |
| 0.07                          | 0.49 | 0.31 |

| Deposition Data |           |         |                |  |                 |
|-----------------|-----------|---------|----------------|--|-----------------|
| Diameter        | Current   | Voltage | Efficiency (%) | Fusion time per electrode at 90% I max | Deposition Rate |
| 2.5 x 350 mm    | 70-100 A  | 24 V    | 60 %           | 58 sec                                 | 0.7 kg/h        |
| 3.2 x 350 mm    | 100-140 A | 23 V    | 61 %           | 60 sec                                 | 1.1 kg/h        |
| 4.0 x 450 mm    | 120-170 A | 21 V    | 64 %           | 96 sec                                 | 1.4 kg/h        |
| 5.0 x 450 mm    | 160-250 A | 21 V    | 66 %           | 105 sec                                | 2.0 kg/h        |