

OK 48.00



A reliable, general purpose electrode for manual metal arc welding of carbon steels, carbon manganese steels and fine-grained carbon manganese steels with elevated yield strength. OK 48.00 deposits a tough, crack-resistant weld metal. The coating is of the low moisture absorption type. High welding speed in the vertical-up position. OK 48.00 is insensitive to the composition of the base material within fairly wide limits. The electrode can be used for welding structures where difficult stress conditions cannot be avoided.

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|-------------------------|--|
| Classifications: | EN ISO 2560-A:E 42 4 B 42 H5, SFA/AWS A5.1:E7018 H4 R |
| Approvals: | CE EN 13479, ABS 3Y H5, PRS 3Y H5, BV 3Y H5, GL 3Y H5, DNV 3Y H5, RS 3Y H5, LR 3Ym H5, DB 10.039.12, VdTÜV 00690, NAKS/HAKC 2.0-5.0 mm |

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

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| Welding Current: | DC+(-) |
| Diffusible Hydrogen: | < 4.0 ml/100g |
| Alloy Type: | Carbon-Manganese |
| Coating Type: | Lime Basic |

Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|------------|----------------|------------------|------------|
| ISO | | | |
| As welded | 475 MPa | 565 MPa | 29 % |

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|------------|---------------------|--------------|
| AWS | | |
| As welded | -30 °C | 130 J |
| ISO | | |
| As welded | -30 °C | 130 J |
| As welded | -40 °C | 115 J |

Typical Weld Metal Analysis %

| C | Mn | Si |
|------|-----|-----|
| 0.06 | 1.1 | 0.5 |