

OK 46.16

All-round, all-positional rutile electrode for thin and medium thick plates. Good striking and restriking properties. A relatively thick coating makes the electrode weld quietly with little spatter.

Specifications	
Classifications	SFA/AWS A5.1 : E7014 EN ISO 2560-A : E 38 0 RC 11
Approvals	ABS : 2 BV : 2 CE : EN 13479 DB : 10.039.37 DNV : 2 UKCA : EN 13479 VdTÜV : 02528

Welding Current	AC, DC+-
Alloy Type	Carbon Manganese
Coating Type	Rutile-cellulosic covering

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	440 MPa	510 MPa	26 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	0 °C	60 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.09	0.5	0.4

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.0 x 300.0 mm	50-70 A	24 V	57 %	40 sec	0.54 kg/h
2.5 x 350.0 mm	60-100 A	25 V	60 %	49 sec	0.9 kg/h
3.2 x 350.0 mm	80-150 A	23 V	58 %	59 sec	1.3 kg/h
4.0 x 350.0 mm	100-200 A	24 V	59 %	65 sec	1.8 kg/h