

## 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.

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

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 covering

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	440 MPa	515 MPa	26 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As Welded	0 °C	70 J

### Typical Weld Metal Analysis %

C	Mn	Si
0.07	0.48	0.31

### Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 350.0 mm	70-100 A	24 V	93	58 sec	60 %	0.7 kg/h
3.2 x 350.0 mm	100-140 A	23 V	57	60 sec	61 %	1.1 kg/h
4.0 x 350.0 mm	120-170 A	20 V	37	73 sec	62 %	1.3 kg/h
4.0 x 450.0 mm	120-170 A	21 V	27	96 sec	64 %	1.4 kg/h
5.0 x 450.0 mm	160-250 A	21 V	17	105 sec	66 %	2.0 kg/h