

# OK 48.60



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

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

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

<b>Welding Current</b>	DC+
<b>Diffusible Hydrogen</b>	< 5.0 ml/100g
<b>Alloy Type</b>	Carbon Manganese
<b>Coating Type</b>	Basic covering

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	445 MPa	540 MPa	28 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
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	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	70-110 A	24 V	65	57 sec	67 %	0.96 kg/h
3.2 x 350.0 mm	90-140 A	23 V	42	68 sec	70 %	1.24 kg/h
3.2 x 450.0 mm	90-140 A	23 V	31	85 sec	73 %	1.33 kg/h
4.0 x 350.0 mm	120-190 A	24 V	29	75 sec	70 %	1.63 kg/h
4.0 x 450.0 mm	120-190 A	24 V	22	92 sec	71 %	1.76 kg/h
5.0 x 450.0 mm	190-260 A	24 V	13	99 sec	75 %	2.61 kg/h