OK GoldRox



OK GoldRox is a true all-round and all-position rutile electrode. With exceptional arc stability and reduced spatter for decreased cleaning time, start and restart properties that allow for easy tack welds, and brilliant slag removal, novice and experienced welders can rely on OK GoldRox. Available in different package sizes – all fully recyclable – to make sure each pack fits specific job requirements.

Specifications	
Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 42 0 RC 11
Approvals	ABS : 2 BV : 2 CE : EN 13479 DB : 10.039.48 DNV : 2 LR : 2 UKCA : EN 13479 VdTÜV : 19622

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

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

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	450 MPa	520 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**
0.07	0.45	0.42

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.0 x 300 mm	50-70 A	25 V	60 %	38 sec	0.55 kg/h
2.5 x 350 mm	60-90 A	25 V	62 %	49 sec	0.8 kg/h
3.2 x 350 mm	90-140 A	24 V	59 %	57 sec	1.1 kg/h
4.0 x 350 mm	110-185 A	26 V	58 %	64 sec	1.4 kg/h