

OK 46.00



OK 46.00 is the best, all-round, rutile electrode and it is relatively insensitive to rust or other surface impurities. It deposits smooth weld beads in all positions, including vertical down, and the slag is easy to remove. OK 46.00 is very easy to strike and restrike, making it ideal for short welds, root runs and tacking.

Classifications:	SFA/AWS A5.1:E6013, EN ISO 2560-A:E 38 0 RC 11, GOST 9467-75:E46, GOST R ISO 2560-A:E 38 0 RC 11
Approvals:	ABS 2, BV 2, CE EN 13479, DB 10.039.05, DNV 2, GL 2, LR 2, RS 2, VdTÜV 00623, BKI 2, ClassNK KMW2, NAKS/HAKC 2.5, 3.0, 4.0, 5.0 mm, NAKS/HAKC 3.0-4.0 mm, NAKS/HAKC 3.2-4.0 mm, RRR 2

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

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	400 MPa	510 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	0 °C	70 J

Typical Weld Metal Analysis %

C	Mn	Si
0.08	0.42	0.30

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
1.6 x 300 mm	30-60 A	26 V	0.63 kg	263	36 sec	0.38 kg/h
2.0 x 300 mm	50-70 A	25 V	0.60 kg	172	38 sec	0.55 kg/h
2.5 x 350 mm	60-100 A	22 V	0.65 kg	86	50 sec	0.80 kg/h
3.0 x 350 mm	70-140 A	32 V	0.51 kg	77	46 sec	1.0 kg/h
3.2 x 350 mm	80-150 A	22 V	0.65 kg	53	57 sec	1.30 kg/h
3.2 x 450 mm	80-150 A	22 V	0.64 kg	43	63 sec	1.33 kg/h
4.0 x 350 mm	100-200 A	22 V	0.60 kg	39	65 sec	1.60 kg/h
4.0 x 400 mm	100-200 A	26 V	0.60 kg	33	64 sec	1.69 kg/h

OK 46.00

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
4.0 x 450 mm	100-200 A	23 V	0.58 kg	33	76 sec	1.94 kg/h
5.0 x 350 mm	150-290 A	24 V	0.60 kg	24	87 sec	2.30 kg/h
5.0 x 400 mm	150-290 A	30 V	0.56 kg	22	71 sec	2.2 kg/h
5.0 x 450 mm	150-290 A	24 V	0.60 kg	31	114 sec	2.30 kg/h