



OK 46.00

SMAW

OK 46.00 is the best, all-around, 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.

Recovery

95%

Welding Current

AC, DC + - OCV 50 V



PACKING/ORDERING INFORMATION				
Part Number	Dia (mm)	Inner Carton (kg)	Carton Weight (kg)	Pallet Weight (kg)
4600162110	1.6	2.0	12.0	924.0
4600202110	2.0	2.0	12.0	924.0
4600253NRO	2.5	5.0	20.0	1000.0
4600323NRO	3.2	5.0	20.0	1000.0
460040HNRO	4.0	5.0	20.0	1000.0
460050HNRO	5.0	5.0	20.0	1000.0

CLASSIFICATIONS	APPROVALS	TYPICAL ALL WELD METAL COMPOSITION (%)	TYPICAL MECH. PROPERTIES ALL WELD METAL
<u>SFA/AWS A5.1</u>	ABS 2	C 0.08	<u>Yield Stress, Mpa</u> 400
E6013	BV 2	Si 0.3	<u>Tensile Strength, Mpa</u> 510
<u>ISO 2560-A</u>	DNV 2	Mn 0.4	<u>Elongation, %</u> 28
E 38 0 RC 11	GL 2		<u>Charpy V</u>
	LR 2M		Test Temps, °C Impact Values, J
	NK KMW2		0 70
			-20 35

WELDING PARAMETERS							
Diameter (mm)	Length (mm)	Welding Current, A	Arc Voltage, V	N. Kg Weld Metal/(kg) Electrodes	B. No. Of Electrodes/(kg) Weld Metal	H. Kg Weld Metal/(hour) Arc Time	T. Burn-off time, (secs)/ Electrode
1.6	300	30-60	20	0.63	263	0.38	36
2.0	300	50-70	21	0.60	172	0.55	38
2.5	350	60-100	22	0.65	86.0	0.8	50
3.2	350	80-150	22	0.65	53.0	1.3	57
4.0	350	100-200	22	0.60	39.0	1.6	65
5.0	350	150-290	24	0.60	24.0	2.3	87
5.0	450	170-220	24	0.60	31.0	2.3	114

