



# OK 48.04

SMAW

OK 48.04 is an AC/DC, general purpose, LMA electrode for welding mild and low-alloy steels. It has very good welding properties and deposits a high quality weld metal with very good mechanical properties. The electrode can be used for welding restrained structures where high welding stresses cannot be avoided.

## Recovery

125%

## Welding Current

AC, DC + (-) OCV 65 V



PACKING/ORDERING INFORMATION				
Part Number	Dia (mm)	Inner Carton (kg)	Carton Weight (kg)	Pallet Weight (kg)
3380324N00	3.2	6.0	18.0	972.0
3380404N00	4.0	6.0	18.0	972.0
3380504N00	5.0	6.0	18.0	972.0
33805070C0	5.0	16.0	16.0	1056.0

CLASSIFICATIONS	APPROVALS	TYPICAL ALL WELD METAL COMPOSITION (%)	TYPICAL MECH. PROPERTIES ALL WELD METAL
<u>SFA/AWS A5.1</u> E7018	ABS 3H5, 3Y BV 3YHH	C 0.06 Si 0.5	<u>Yield Stress, Mpa</u> 480
<u>ISO 2560-A</u> E 42 4 B 32 H5	DNV 3YH10 GL 3YH10 LR 3, 3YH15	Mn 1.1	<u>Tensile Strength, Mpa</u> 560
			<u>Elongation, %</u> 30
			<u>Charpy V</u> Test Temps, °C    Impact Values, J
			-20                    150
			-40                    100

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
2.0	300	50-80	23	0.61	125	0.67	44
2.5	350	70-110	23	0.64	67.0	1.0	59
3.2	350	110-150	22	0.63	42.3	1.37	62.4
3.2	450	110-150	25	0.67	30.0	1.5	92
4.0	450	150-200	26	0.68	20.0	2.0	101
5.0	450	190-260	26	0.72	13.0	2.8	105

