



OK 48.08

SMAW

OK 48.08 is an LMA electrode with very good mechanical properties suitable for demanding applications, such as offshore. The weld metal contains approximately 1% Ni for high impact values down to -40°C. The coating is of the latest LMA type for optimum resistance to porosity and hydrogen cracking. OK 48.08 is CTOD tested.

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)
VacPac				
4808253NV0	2.5	2.9	11.6	580.0
480832HNV0	3.2	3.5	14.0	700.0
480840HNV0	4.0	3.7	14.8	740.0
480850HNV0	5.0	4.0	16.0	800.0

CLASSIFICATIONS	APPROVALS		TYPICAL ALL WELD METAL COMPOSITION (%)		TYPICAL MECH. PROPERTIES ALL WELD METAL	
			C	0.06	Yield Stress, Mpa	540
SFA/AWS A5.5	ABS	3H5 3Y H5	Si	0.4	Tensile Strength, Mpa	600
E7018-G	DNV	4 Y40H10	Mn	1.2	Elongation, %	26
EN ISO 2560-A	GL	4YH5	Ni	0.8	Charpy V	
E 46 5 Ni B 32 H5	LR	4Y40M H5			Test Temps, °C	Impact Values, J
					-20	160
					-40	130
					-50	100
					-60	60

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	55-80	22	0.57	135.1	0.6	42
2.5	350	75-110	27	0.57	88.2	1.0	41
3.2	350	110-150	22	0.62	42.3	1.3	66
3.2	450	110-150	22	0.66	30.0	1.4	85
4.0	350	150-200	22	0.66	26.5	2.0	68
4.0	450	150-200	22	0.69	20.3	2.0	90
5.0	450	190-275	23	0.69	14.0	3.0	85
6.0	450	220-360	26	0.66	10.0	3.8	95

