



# OK 55.00

SMAW

OK 55.00 is a reliable, high quality, LMA electrode, particularly suitable for welding high strength low-alloy steels. The good, low-temperature impact strength of the weld metal should be noted. The weld metal is also very resistant to hot cracking. The electrode is also suitable for welding high strength ship's steel, grades A, D and E.

## 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)
5500253NR0	2.5	5.0	20.0	1000.0
550032HNRO	3.2	5.0	20.0	1000.0
550040HNRO	4.0	5.0	20.0	1000.0
550050HNRO	5.0	5.0	20.0	1000.0
VacPac				
5500253NV0	2.5	3.0	12.0	600.0
550032HNVO	3.2	3.7	14.8	740.0
550040HNVO	4.0	3.7	14.8	740.0
550050HNVO	5.0	4.0	16.0	800.0

CLASSIFICATIONS	APPROVALS	TYPICAL ALL WELD METAL COMPOSITION (%)	TYPICAL MECH. PROPERTIES ALL WELD METAL
<u>SFA/AWS A5.1</u>	ABS 3H5, 3Y H5	C 0.07	<u>Yield Stress, Mpa</u>
E7018-1	BV 3Y H5	Si 0.5	480
<u>CSA W48</u>	DNV 4Y H5	Mn 1.4	<u>Tensile Strength, Mpa</u>
E4918-1	LR 3M, 3YM, M5		590
<u>CSN 05 5010</u>			<u>Elongation, %</u>
E 55.93			28
<u>EN ISO 2560-A</u>			<u>Charpy V</u>
E 46 5 B 32 H5			Test Temps, °C    Impact Values, J
			-20                    115
			-50                    50

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
2.5	350	80-110	23	0.64	65.8	0.86	64
3.2	350	110-140	23	0.62	41.1	1.22	72
3.2	450	110-140	24	0.69	30.0	1.4	88
4.0	350	140-200	23	0.62	28.0	1.77	72
4.0	450	140-200	24	0.70	19.0	2.0	94
5.0	450	200-270	24	0.72	13.0	3.0	94
6.0	450	215-360	25	0.72	9.0	4.0	98

