

OK 48.04



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.

Classifications:	EN ISO 2560-A:E 42 4 B 32 H5, SFA/AWS A5.1:E7018
Approvals:	CE EN 13479, ABS 3Y H5, PRS 3Y H5, BV 3Y H5, GL 3Y H5, DNV 3Y H5, Seproz UNA 272580, RS 3Y H5, NAKS/HAKC 2.5-5.0 mm, ABS AWS A5.1 - E7018, LR 3Ym H15

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

Welding Current:	AC, DC+(-)
Diffusible Hydrogen:	<5.0 ml/100g
Alloy Type:	Carbon Manganese
Coating Type:	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	480 MPa	560 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	-30 °C	110 J
As welded	-40 °C	100 J

Typical Weld Metal Analysis %

C	Mn	Si
0.06	1.2	0.6

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 90% I max
2.5 x 350 mm	75-110 A	23 V	0.64	67.0	59 s	1.00 kg/h
3.2 x 350 mm	90-155 A	22 V	0.63	42.3	62.4 s	1.37 kg/h
3.2 x 450 mm	90-155 A	25 V	0.67	30.0	92 s	1.50 kg/h
4.0 x 450 mm	125-200 A	26 V	0.68	20.0	101 s	2.00 kg/h
5.0 x 450 mm	190-260 A	26 V	0.72	13.0	106 s	2.80 kg/h