

OK 46.30

All-round, general purpose rutile electrode for thin and medium thick plates. Good striking and restriking properties, suitable for tack welding. Useful for bridging gaps.

Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 38 0 R 12
Approvals	CE : EN 13479

Welding Current	AC, DC+-
Alloy Type	Carbon Manganese
Coating Type	Rutile covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	440 MPa	515 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	0 °C	70 J

Typical Weld Metal Analysis %

C	Mn	Si
0.07	0.48	0.31

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	70-100 A	24 V	60 %	93	58 sec	0.7 kg/h
3.2 x 350.0 mm	100-140 A	23 V	61 %	57	60 sec	1.1 kg/h
4.0 x 350.0 mm	120-170 A	20 V	62 %	37	73 sec	1.3 kg/h
4.0 x 450.0 mm	120-170 A	21 V	64 %	27	96 sec	1.4 kg/h
5.0 x 450.0 mm	160-250 A	21 V	66 %	17	105 sec	2.0 kg/h