

OK 48.60

General purpose basic DC+ electrode for mild and low alloy steels. Very good running characteristics.

Classifications	SFA/AWS A5.1 : E7018 EN ISO 2560-A : E 42 4 B 42 H5
Approvals	ABS : 3Y H5 BV : 3Y H5 CE : EN 13479 DB : 10.039.23 DNV : 3 YH5 GL : 3YH5 LR : 3Y H5 VdTÜV : 10094

Welding Current	DC+
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	445 MPa	540 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-40 °C	70 J
As Welded	-30 °C	80 J

Typical Weld Metal Analysis %

C	Mn	Si
0.04	1.19	0.64

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	70-110 A	24 V	67 %	65	57 sec	0.96 kg/h
3.2 x 350.0 mm	90-140 A	23 V	70 %	42	68 sec	1.24 kg/h
3.2 x 450.0 mm	90-140 A	23 V	73 %	31	85 sec	1.33 kg/h
4.0 x 350.0 mm	120-190 A	24 V	70 %	29	75 sec	1.63 kg/h
4.0 x 450.0 mm	120-190 A	24 V	71 %	22	92 sec	1.76 kg/h
5.0 x 450.0 mm	190-260 A	24 V	75 %	13	99 sec	2.61 kg/h