# OK 48.00

**Type** Lime-basic

**SMAW**
E7018

## Description

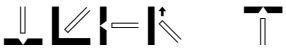
A reliable, general purpose, LMA electrode for mild and low-alloy steels. OK 48.00 deposits a tough, crack-resistant weld metal. High welding speed in the vertical-up position. OK 48.00 is insensitive to the composition of the base material within fairly wide limits. The electrode can be used for welding structures where difficult stress conditions cannot be avoided.

### Recovery

125%

### Welding current

DC+(-)



## Classifications

| | |
|---|---|
| SFA/AWS A5.1 | E7018 |
| CSA W48 | E4918 |
| EN 499 | E 42 4 B 42 H5 |
| ISO 2560 | E51 5B 120 20H |

## Typical all weld metal composition, %

| C | Si | Mn |
|---|---|---|
| 0.06 | 0.5 | 1.2 |

## Typical mech. properties all weld metal

| | |
|---|---|
| Yield stress, MPa | 445 |
| Tensile strength, MPa | 540 |
| Elongation, % | 29 |

### Charpy V

| Test temps, °C | Impact values, J |
|---|---|
| -20 | 140 |
| -40 | 70 |

## Approvals

| | | | |
|---|---|---|---|
| ABS | 3H5, 3Y | RINA | E 52 3 HH |
| BV | 3, 3Y H5 | RS | 3YHH |
| CL | | Sepros | |
| CWB | CSA W48 | SFS | EN 499 |
| DB | 10.039.12 | SS | EN 499 |
| DNV | 3Y H5 | UDT | EN 499 |
| DS | EN 499 | Ü | 10.039/12 |
| GL | 3Y H5 | VdTÜV | |
| LR | 3,3Y H5 | | |
| PRS | 3YH10 | | |

## 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, s/ electrode |
|---|---|---|---|---|---|---|---|
| 1.6 | 300 | 30-55 | 22 | | | | |
| 2.0 | 300 | 50-80 | 24 | | | | |
| 2.5 | 350 | 80-110 | 23 | 0.65 | 62.5 | 1.0 | 56 |
| 3.2 | 350 | 90-140 | 22 | 0.64 | 43 | 1.3 | 66 |
| 3.2 | 450 | 90-140 | 23 | 0.64 | 32.3 | 1.5 | 76 |
| 4.0 | 350 | 125-210 | 24 | 0.51 | 35.0 | 2.1 | 64 |
| 4.0 | 450 | 125-210 | 26 | 0.67 | 20.5 | 2.1 | 86 |
| 5.0 | 450 | 200-260 | 23 | 0.69 | 13.5 | 2.6 | 102 |
| 6.0 | 450 | 220-340 | 23 | 0.72 | 9.6 | 3.7 | 102 |
| 7.0 | 450 | 280-410 | 25 | 0.72 | 7.0 | 4.4 | 117 |