

OK 55.00

Type Lime-basic

SMAW

E7018-1

Description

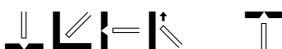
OK 55.00 is a reliable, high-quality, LMA electrode, particularly suitable for welding high strength low-alloy steels. The good, low-temperature impact strength of the weld metal should be noted. The weld metal is also very resistant to hot cracking. The electrode is also suitable for welding high strength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

Recovery

125%

Welding current

AC, DC+ OCV 65 V



Classifications

SFA/AWS A5.1	E7018-1
CSA W48	E4918-1
CSN 05 5010	E 55.93
EN 499	E 46 5 B 32 H5
ISO 2560	E 51 5B 120 26H

Typical all weld metal composition, %

C	Si	Mn
0.07	0.5	1.4

Typical mech. properties all weld metal

Yield stress, MPa	480
Tensile strength, MPa	590
Elongation, %	28

Charpy V

Test temps, °C	Impact values, J
-20	115
-50	50

Approvals

ABS	3H5 , 3Y H5 Ü	10.039/1
BV	3Y H5 VdTÜV	00632
CL	EN 499	
CWB	CSA W48	
DB	10.039.03	
DNV	4YH5	
DS	EN 499	
GL	3YH5	
LR	3, 3Y H5	
RS	3YHH	
Sepros		
SFS	EN 499	
SS	EN 499	
UDT	EN 499	

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
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