OK 55.00

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 ships steel, grades A, D and E.

Classifications	SFA/AWS A5.1: E7018-1H4 R CSA W48: E4918-1-H4 EN ISO 2560-A: E 46 5 B 32 H5
Approvals	ABS 3Y H5 BV 3Y H5 CE EN 13479 CWB E4918-1-H4 DB 10.039.03 DNV 3Y H5 GL 3Y H5 LR 3Y H5 NAKS/HAKC 5.0mm RS 3Y H5 VdTÜV 00632

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

Welding Current	AC, DC+
Diffusible Hydrogen	< 4.0 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	500 MPa	590 MPa	28 %
AWS			

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-45 °C	-
As Welded	-50 °C	-
AWS		
As Welded	-45 °C	-

Typical Weld Metal Analysis %

C	Mn	Si
0.06	1.5	0.5

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
2.5 x 350 mm	80-110 A	23 V	0.64	66	64 sec	0.9 kg/h
3.2 x 350 mm	110-140 A	23 V	0.62	41	72 sec	1.2 kg/h
3.2 x 450 mm	110-140 A	24 V	0.69	30	88 sec	1.4 kg/h
4.0 x 350 mm	140-200 A	23.2 V	0.62	28	72.5 sec	1.77 kg/h
4.0 x 450 mm	140-200 A	24 V	0.71	19	94 sec	2.0 kg/h
5.0 x 450 mm	200-270 A	24 V	0.72	13	94 sec	3.0 kg/h
6.0 x 450 mm	215-360 A	25 V	0.72	9	98 sec	4.0 kg/h

410018-en_WW-FactSheet_Main-01 2020-11-24