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.

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

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

Welding Current	AC, DC+(-)
Alloy Type	Carbon Manganese
Coating Type	Rutile covering
Min AC OCV	50V

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	0.49	0.31

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 350.0 mm	70-100 A	24 V	60 %	58 sec	0.7 kg/h
3.2 x 350.0 mm	100-140 A	23 V	61 %	60 sec	1.1 kg/h
4.0 x 450.0 mm	120-170 A	21 V	64 %	96 sec	1.4 kg/h
5.0 x 450.0 mm	160-250 A	21 V	66 %	105 sec	2.0 kg/h