

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.

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

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	0.48	0.31

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	70-100 A	24 V	0.60 kg	93	58 sec	0.7 kg/h
3.2 x 350 mm	100-140 A	23 V	0.61 kg	57	60 sec	1.1 kg/h
4.0 x 350 mm	120-170 A	20 V	0.62 kg	37	73 sec	1.3 kg/h
4.0 x 450 mm	120-170 A	21 V	0.64 kg	27	96 sec	1.4 kg/h
5.0 x 450 mm	160-250 A	21 V	0.66 kg	17	105 sec	2.0 kg/h