



Product Data Sheet

OK 46.30

E 'Manual metal-arc welding'
ESAB-MÓR Kft Hungary

Prepared by A-C Thorsson	Qualified by Tero Borg	Approved by J-P Ernoult	Reg no EN007344	Cancelling EN007041	Reg date 2016-08-05	Page 1 (2)
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REASON FOR ISSUE

Coating type amended. Economy data updated.

GENERAL

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.

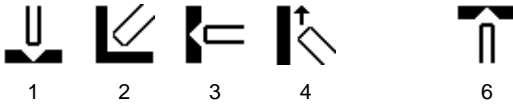
Min AC OCV: 50

Alloy Type: Carbon Manganese

Polarity: AC, DC+-

Coating Type: Rutile covering

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.1 E6013
 EN ISO 2560-A E 38 0 R 12

APPROVALS

CE EN 13479

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.05	0.12
Si	0.30	0.70
Mn	0.25	0.75
P		0.030
S		0.030
Cr		0.19
Ni		0.29
Mo		0.19
V		0.049
Nb		0.049
Cu		0.29

MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO			AWS
	As welded Min	Max	Typ	As welded Min
Rp0.2 (MPa)				330
ReL (MPa)	380		440	
Rm (MPa)	470	600	515	430
A4 (%)				17
A5 (%)	20		26	
Charpy V at 0°C (J)	47		70	



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ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 350	70	100	1.8	92	0.60	93	0.7	58	24	1,2,3,4,6
3.2 x 350	100	140	2.9	95	0.61	57	1.1	60	23	1,2,3,4,6
4.0 x 350	120	170	4.3	94	0.62	37	1.3	73	20	1,2,3,4,6
4.0 x 450	120	170	5.6	94	0.64	27	1.4	96	21	1,2,3,4,6
5.0 x 450	160	250	8.8	96	0.66	17	2.0	105	21	1,2,3,4

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)