



Product Data Sheet

E 'Manual metal-arc welding'
ESAB Perstorp AB Sweden

OK GPC
Former OK 21.03

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REASON FOR ISSUE

Diameter 6.0mm deleted. Welding positions for diameter 5.0mm amended.

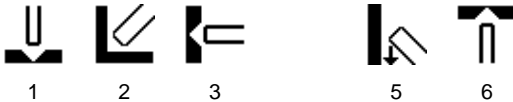
GENERAL

OK GPC is designed for gouging, cutting and piercing mild and alloyed steel, cast iron and non-ferrous metals with the exception of pure copper, using standard welding equipment. The electrode can be used in a wide variety of applications, e.g. for bevelling, for preparation of cracked areas before welding, for back-gouging of root runs.

Min AC OCV: 65

Polarity: AC, DC-

WELDING POSITIONS



CLASSIFICATIONS weld metal

Not applicable

APPROVALS

Not applicable

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	100	120							43	1,2,3,5,6
3.2 x 350	130	180							43	1,2,3,5,6
4.0 x 350	170	230							48	1,2,3,5,6
5.0 x 450	230	300							48	1,2,3,5,6

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)

OTHER DATA

Gouging speed: 1-1.5 m/min