

**Електроди Esab заваръчни 3.2x350 мм, 5.5 кг, 150 А,
рутилови, ОК 46.00**



Type Rutile

OK 46.00 is the best, all-round, rutile electrode and it is relatively insensitive to rust or other surface impurities. It deposits smooth weld beads in all positions, including vertical down, and the slag is easy to remove. OK 46.00 is very easy to strike and restrike, making it ideal for short welds, root runs and tacking.

Welding current AC, DC+/-, OCV 50 V



Classifications	Approvals		Typical all weld metal composition, %	Typical mech. properties all weld metal
EN ISO 2560-A	ABS	2	C 0,08	Yield stress, MPa 400 Tensile strength, MPa 510 Elongation, % 28 Elongation, % 28 Charpy V Test Impact temps, values, °C J
E 38 0 RC 11	BV	2	Si 0,3	
SFA/AWS A5.1	DB	10.039.05	Mn 0,4	
E6013	DNV	2	P ³ 0,03	
	GL	2	S ³ 0,03	
	LR	2		
	VdTÜV	00623		
	CE	EN 13479		
	Class NK	KMW2		
	BKI	2 (ID)		

Ташев-Галвинг
www.tashev-galvin.com

Redrying temperature, °C 70-80

Redrying time, hours 1

Recovery 95%

Diameter, mm	1,6	2,0	2,5	3,2	4,0	5,0
Length, mm	300	300	350	350	350	350
Arc voltage, V	26	25	22	22	22	24
Welding current, A	30-60	50-70	60-100	80-150	100-200	150-290
N. Kg weld metal/kg electrodes	0,63	0,60	0,65	0,65	0,60	0,60
B. No. of electrodes/kg weld metal	263	172	86	53	39	24
H. Kg weld metal/hour arc time	0,38	0,55	0,80	1,30	1,60	2,30
T. Burn-off time, s/electrode	36	38	50	57	65	87

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Категория: [Електродъгово заваряване](#)

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