

**Електроди Esab заваръчни 2.5x350 мм, 4.5 кг, 110 А,
стоманени, ОК 48.00**



Ташев-Галвинг
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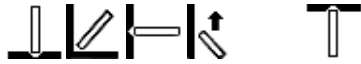
OK 48.00

Type Lime-basic

A reliable, general purpose, LMA electrode for mild and low-alloy steels. OK 48.00 deposits a tough, crack-resistant weld metal. High welding speed in the vertical-up position. OK 48.00 is insensitive to the composition of the base material within fairly wide limits. The electrode can be used for welding structures where difficult stress conditions cannot be avoided.

Welding current

DC+/-



Classifications	Approvals		Typical all weld metal composition, %		Typical mech. properties all weld metal	
SFA/AWS A5.1 E7018 EN ISO 2560-A E 42 4 B 42 H5	ABS	3YH5	C	0,06	Yield stress, MPa	
	DB	10.039.12	Si	0,5	445	
	DNV	3YH5	Mn	1,2	Tensile strength, MPa	
	GL	3YH5	P	0,02	540	
	LR	3YH5	S	0,015	Elongation, %	
	VdTÜV	00690			29	
	CE	EN 13479			Elongation, %	
	BV	3YH5			29	
	PRS	3YH5			Charpy V	
	RS	3YH5			Test temps, °C	Impact values, J
				-20	140	
				-40	70	
Redrying temperature, °C						
350						
Redrying time, hours						
2						
Recovery						
125%						

Diameter, mm	1,6	2,0	2,5	3,2	3,2	4,0	4,0	5,0	5,0	6,0	7,0
Length, mm	300	300	350	350	450	350	450	350	450	450	450
Arc voltage, V	24	22	23	22	23	24	26	23	23	23	25
Welding current, A	30-55	50-80	80-110	90-140	90-140	125-210	125-210	200-260	200-260	220-340	280-410
N. Kg weld metal/kg electrodes	0,59	0,63	0,65	0,64	0,64	0,51	0,67	0,53	0,69	0,72	0,72
B. No. of electrodes/kg weld metal	192	119	62,5	43	32,3	35,0	20,5	23,0	13,5	9,6	7,0
H. Kg weld metal/hour arc time	0,38	0,6	1,0	1,3	1,5	2,1	2,1	2,6	2,6	3,7	4,4
T. Burn-off time, s/electrode	50	50	56	66	76	64	86	78	102	102	117

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Категория: [Електродъгово заваряване](#)

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