

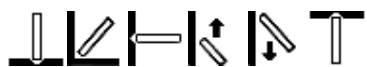
**Електроди Esab заваръчни 2.5x350 мм, 5.5 кг, 100 А,  
рутилови, ОК 46.00**



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

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<br>time,<br>s/electrode | 36 | 38 | 50 | 57 | 65 | 87 |
|-------------------------------------|----|----|----|----|----|----|

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Категория: [Електродъгово заваряване](#)

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