

OK 48.15



An LMA electrode for welding mild and low-alloy steels. Exceptional welding properties in the vertical-up position. OK 48.15 gives the same good weld metal quality as OK 48.00, which makes the electrode suitable for welding structures in which high stresses cannot be avoided. It is also suitable for welding galvanised plate.

Beteckning	SFA/AWS A5.1: E7018 EN ISO 2560-A: E 42.3 B 32 H5
Godkännanden	ABS E7018 ABS 3Y H5 BV 3Y H5 CE EN 13479 DB 10.039.06 DNV-GL 3 YH5 LR 3Ym H5 PRS 3Y H5 RS 3Y H5 VdTUV 00625

Godkännanden baseras på fabriken lokaliserings. Vänligen kontakta ESAB för mer information.

Welding Current	AC, DC+(-)
Diffusible Hydrogen	< 5 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	490 MPa	575 MPa	30 %
AWS			

Slagseghetsdata Charpy V

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-30 °C	60 J
AWS		
As Welded	-30 °C	-

Typical Wire Composition %

C	Mn	Si
0.06	1	0.5

Insmålningsdata

Diameter	Ampere	Volt	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Insmålningshastighet
2.0 x 300 mm	55-80 A	22 V	0.61	125.0	43 sec	0.70 kg/h
2.5 x 350 mm	65-110 A	22 V	0.60	67.0	60 sec	1.00 kg/h
3.2 x 450 mm	100-140 A	23 V	0.66	31.0	84 sec	1.40 kg/h
4.0 x 450 mm	140-200 A	24 V	0.66	21.0	89 sec	2.00 kg/h