



Product Data Sheet

OK 48.50 T

E 'Manual metal-arc welding'
ESAB-MÓR Kft Hungary

Prepared by A-C Thorsson	Qualified by P-O Oskarsson	Approved by J-P Ernoult	Reg no EN007582	Cancelling EN006721	Reg date 2017-07-10	Page 1 (2)
-----------------------------	-------------------------------	----------------------------	--------------------	------------------------	------------------------	---------------

REASON FOR ISSUE

New ABS grade.

GENERAL

Basic AC/DC LMA electrode for general purpose welding.

Min AC OCV: 65

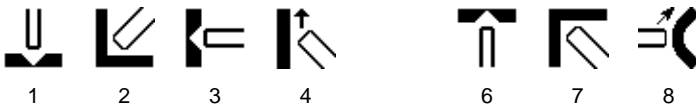
Polarity: AC, DC+(-)

Alloy Type: Carbon Manganese

Coating Type: Basic covering

Diff Hydrogen: < 5ml/100g

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.1

E7018-1

EN ISO 2560-A

E 42 4 B 32 H5

APPROVALS

ABS

4Y H5

CE

EN 13479

LR

3YH5

RINA

4Y H5

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.05	0.10
Si	0.25	0.60
Mn	1.00	1.40
P		0.020
S		0.020
Cr		0.1
Ni		0.1
Mo		0.2
V		0.03
Nb		0.049
Cu		0.1

MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO		AWS
	As welded Min	Max	As welded Min
ReL (MPa)	420		400
Rm (MPa)	500	640	490
A4 (%)			22
A5 (%)	20		
Charpy V at -40°C (J)	47		
Charpy V at -45°C (J)			27



Product Data Sheet

OK 48.50 T

E 'Manual metal-arc welding'
ESAB-MÓR Kft Hungary

Prepared by A-C Thorsson	Qualified by P-O Oskarsson	Approved by J-P Ernoult	Reg no EN007582	Cancelling EN006721	Reg date 2017-07-10	Page 2 (2)
-----------------------------	-------------------------------	----------------------------	--------------------	------------------------	------------------------	---------------

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	70	100	2.4	128	0.62	68	0.9	59	24	1,2,3,4,6,7,8
3.2 x 450	90	140	4.7	123	0.65	33	1.3	85	23	1,2,3,4,6,7,8
4.0 x 450	120	180	7.0	120	0.66	22	1.6	104	22	1,2,3,4,6,7,8
5.0 x 450	180	230	10.3	118	0.68	14	2.2	114	22	1,2,3,4

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)