

OK 53.70



A low hydrogen AC/DC electrode for one side welding of pipes and general structures. The root penetration is good, leaving a flat bead with easy removable slag. The stable arc and the well balanced slag system make the electrode easy to weld in all positions. Suitable for welding of transmission pipelines made from pipe steels up to API 5LX56. It is also suitable for welding the root in higher strength pipes, API 5LX60, 5LX65, 5LX70.

Specifications

Classifications	SFA/AWS A5.1 : E7016-1 EN ISO 2560-A : E42 5 B 12 H5
Approvals	ABS : E7016-H4 ABS : 3Y H5 CE : EN 13479 DNV-GL : 3 YH5 LR : 3Y H5 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+(-)
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering
Min AC OCV	60V

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	440 MPa	530 MPa	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-50 °C	100 J

Typical Weld Metal Analysis %

C	Mn	Si
0.06	1.1	0.4

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.0 x 300 mm	50-90 A	27 V	61 %	18 sec	1.63 kg/h
2.5 x 350 mm	60-85 A	26 V	63 %	57 sec	0.7 kg/h
3.2 x 350 mm	80-130 A	24 V	59 %	61 sec	1.1 kg/h
4.0 x 450 mm	115-190 A	24 V	63 %	86 sec	1.7 kg/h
5.0 x 450 mm	150-250 A	24 V	66 %	104 sec	2.26 kg/h