

OK 55.00



OK 55.00 is a reliable, high-quality, LMA electrode, particularly suitable for welding high strength low-alloy steels. The good, low-temperature impact strength of the weld metal should be noted. The weld metal is also very resistant to hot cracking. The electrode is also suitable for welding high strength ships steel, grades A, D and E. Tested according to NACE TM0177 and TM0284. Diffusible Hydrogen tested in various conditions show values below 3 ml/100g.

Specifications	
Classifications	SFA/AWS A5.1 : E7018-1H4 R CSA W48 : E4918-1-H4 EN ISO 2560-A : E 46 5 B 32 H5
Approvals	ABS : 3Y H5 BV : 3Y H5 CE : EN 13479 CWB : E4918-1-H4 DB : 10.039.03 DNV : 3 YH5 LR : 3Y H5 UKCA : EN 13479 VdTÜV : 00632

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

Welding Current	AC, DC+
Diffusible Hydrogen	< 4.0 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering
Min AC OCV	65 V

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	500 MPa	590 MPa	28 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
AWS		
As Welded	-45 °C	105 J
ISO		
As Welded	-50 °C	100 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.08	1.5	0.5

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 350 mm	80-110 A	23 V	64 %	64 sec	0.9 kg/h
3.2 x 350 mm	110-140 A	23 V	62 %	72 sec	1.2 kg/h
3.2 x 450 mm	110-140 A	24 V	69 %	88 sec	1.4 kg/h
4.0 x 350 mm	110-200 A	23 V	62 %	72 sec	1.77 kg/h

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Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
4.0 x 450 mm	110-200 A	24 V	70 %	94 sec	2.0 kg/h
5.0 x 450 mm	200-270 A	24 V	72 %	94 sec	3.0 kg/h
6.0 x 450 mm	215-360 A	25 V	72 %	98 sec	4.0 kg/h