



Product Data Sheet

OK 55.00

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

Prepared by P-O Oskarsson	Qualified by P-O Oskarsson	Approved by J-P Ernoult	Reg no EN007580	Cancelling EN006737	Reg date 2017-07-10	Page 1 (2)
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REASON FOR ISSUE

New CWB approval. New classification according to CSA W48.

GENERAL

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.

Min AC OCV: 65

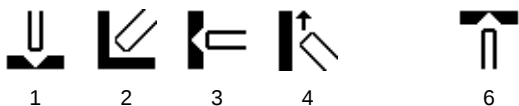
Polarity: AC, DC+

Alloy Type: Carbon Manganese

Coating Type: Basic covering

Diff Hydrogen: < 4.0 ml/100g

WELDING POSITIONS



CLASSIFICATIONS Electrode

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	3Y H5
GL	3Y H5
LR	3Y H5
NAKS/HAKC	5.0mm
RS	3Y H5
VdTÜV	00632

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.05	0.10
Si	0.30	0.70
Mn	1.10	1.60
P		0.030
S		0.030
Cr		0.1
Ni		0.1
Mo		0.1
V		0.03
Nb		0.02
Cu		0.1
Al		0.03
Sn		0.01
Ti		0.03
Pb		0.02
As		0.03



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MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO			AWS
	As welded Min	Max	Typ	As welded Min
Rp0.2 (MPa)				400
ReL (MPa)	460		500	
Rm (MPa)	560	680	590	490
A4 (%)				22
A5 (%)	22		28	
Charpy V at -45°C (J)			105	27
Charpy V at -50°C (J)	47		100	
	Comments: EN standard requires Rm min 530 Mpa and A5 min 20%.			Comments:

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U	Welding Positions
Ø x Length	Min	Max								
2.5 x 350	80	110	2.4	127	0.64	66	0.9	64	23	1,2,3,4,6
3.2 x 350	110	140	3.9	126	0.62	41	1.2	72	23	1,2,3,4,6
3.2 x 450	110	140	5.0	125	0.69	30	1.4	88	24	1,2,3,4,6
4.0 x 350	140	200	5.8	122	0.62	28	1.77	72.5	23.2	1,2,3,4,6
4.0 x 450	140	200	7.4	125	0.71	19	2.0	94	24	1,2,3,4,6
5.0 x 450	200	270	10.8	125	0.72	13	3.0	94	24	1,2,3,4
6.0 x 450	215	360	12.6	125	0.72	9	4.0	98	25	1,2,3

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)