

OK 48.20



A basic coated low-hydrogen electrode for MMAW

Classification AWS A5.1: E 7018
IS: 814 EB 5424H₃JX



DESCRIPTION

OK 48.20 is a heavy basic coated, hydrogen controlled iron powder (high metal recovery of approximately 117%) electrode with excellent running performance and bead finish in flat and positional welding. It deposits a tough and crack-resistant weld of high radiographic quality.

APPROVALS

CIB, MMD, PDIL.

WELDING CURRENT: DC+, AC 70V

TYPICAL APPLICATIONS

Boiler and pressure vessels, penstock, structure and other components under restrained conditions and dynamic loading, ship building, steel of doubtful composition, grey cast iron buffer layer prior to hard facing etc.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.06	Mn	1.15	YS	520 N/mm ²
Si	0.50	S	0.018	UTS	600 N/mm ²
P	0.018			EL (L=5d)	30%
				Impact (CVN) at -30°C	100J

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	70-110	140	560
3.15	450	100-150	95	380
4.00	450	130-190	65	260
5.00	450	180-260	40	160

PACKING: Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box. This electrode can be made available in moisture resistance vacuum packed cartons, which can be used without redrying.