

# OK 48.08

## A low alloy, low hydrogen electrode for MMAW



Classification      AWS A5.5: E 7018-G  
 IS: 1395: E49B-G126Fe

### DESCRIPTION

OK 48.08 is a basic coated Ni alloyed low hydrogen electrode for low temperature applications down to - 50°C. It is an all position electrode for welding medium tensile & fine grained carbon steels with AC and DC power supply. The electrode gives an extremely smooth arc, least spatter with good slag detachability. Weldmetal is of highest radiographic soundness with good mechanical properties and excellent impact strength. The electrode gives deposition efficiency of approx. 115%.

**WELDING CURRENT:** DC ±, AC 70V

### TYPICAL APPLICATIONS

OK 48.08 is especially designed for the welding of low alloy steels such as steels containing 1% Nickel and also for structures to withstand low temperatures.

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.06	Si	0.35	YS	490 N/mm <sup>2</sup>
Mn	1.35	Ni	1.00	UTS	590 N/mm <sup>2</sup>
				EL (L=4d)	24%
				Impact (CVN) at - 50°C	55J

### CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	75-110	130	520
3.15	450	105-150	90	360
4.00	450	140-200	60	240
5.00	450	190-270	40	160

**PACKING:** Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box.