



# Product Data Sheet

OK 43.32

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 EN007498	Cancelling EN007468	Reg date 2017-03-15	Page 1 (2)
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## REASON FOR ISSUE

Current range 2.0 mm amended.

## GENERAL

Easy-to-weld rutile type electrode for welding in the flat position. The good flowing properties of the weld metal give a good finish of the weld beads both on butt and fillet welds. Good slag detachability. The stable arc, also on low welding currents, makes the electrode very suitable for sheet metal welding.

**Min AC OCV:** 50

**Polarity:** AC, DC+-

**Alloy Type:** Carbon Manganese

**Coating Type:** Rutile thick covering

## WELDING POSITIONS



## CLASSIFICATIONS Electrode

SFA/AWS A5.1 E6013  
EN ISO 2560-A E 42 0 RR 12

## APPROVALS

ABS 2  
BV 1  
CE EN 13479  
DB 10.039.36  
DNV-GL 2  
LR 2  
RS 2  
VdTÜV 00621

## CHEMICAL COMPOSITION

### All Weld Metal (%)

	Min	Max
C		0.12
Si	0.35	0.75
Mn	0.25	0.75
P		0.030
S		0.030
Cr		0.19
Ni		0.29
Mo		0.19
V		0.049
Nb		0.049
Cu		0.29



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## MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO			AWS
	As welded Min	Max	Typ	As welded Min
Rp0.2 (MPa)				330
ReL (MPa)	420		460	
Rm (MPa)	510	640	520	430
A4 (%)				17
A5 (%)	22		27	
Charpy V at 0°C (J)	47		60	
Charpy V at -10°C (J)	47		55	
	Comments: EN standard requires Rm min 500 MPa and A5 min 20%.			Comments:

## ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	$\eta$	N	B	H	T	U	Welding Positions
$\varnothing$ x Length	Min	Max								
2.0 x 300	50	80	1.1	94	0.54	167	0.6	36	23	1,2,3,4,6,7
2.5 x 350	50	110	2.0	94	0.54	88	0.9	46	25	1,2,3,4,6,7
3.2 x 350	80	150	3.6	97	0.57	51	1.3	57	26	1,2,3,4,6,7
3.2 x 450	80	140	4.6	97	0.54	40.5	1.3	74	26	1,2,3,4,6,7
4.0 x 350	120	210	5.5	96	0.52	35	1.6	63	25	1,2,3,4,6,7
4.0 x 450	120	210	7.3	97	0.54	27	1.9	76	27	1,2,3,4,6,7
5.0 x 450	170	290	11.0	95	0.56	17	2.5	87	26	1,2,3
6.0 x 450	230	370	15,4	93	0,52	12,4	2,8	105	30,6	1,2,3

- W** = Weight (kg / 100 electrodes)  
 **$\eta$**  = 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)