



Product Data Sheet

OK 49.20

E 'Manual metal-arc welding'
ESAB AB Sweden

Signed by P-O Oskarsson	Approved by Tony Dray/Christos Skodras	Reg no EN004608	Cancelling EN002225	Reg date 2008-10-30	Page 1 (2)
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REASON FOR ISSUE

Change to dimension range

GENERAL

A special electrode used to produce exceptionally low silicon weld deposits e.g. for fabrication of hot Zinc galvanising baths.

Min AC OCV: 50V

Polarity: AC, DC+-

Alloy Type: Carbon-Manganese

Coating Type: Rutile

WELDING POSITIONS



CLASSIFICATIONS Electrode

EN ISO 2560-A E 35 A A 13

APPROVALS

Not applicable

CHEMICAL COMPOSITION

	All Weld Metal (%)	
	Max	
C	0.10	
Si	0.10	
Mn	1.20	
P	0.040	
S	0.030	

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	ISO	
	As welded	
	Min	Max
ReL (MPa)	355	
Rm (MPa)	440	570
A5 (%)	22	
Charpy V at 20°C (J)	47	



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ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U
	Min	Max							
4.0 x 450	125	180	6.6	94.3	0.56	27.3	1.61	82.1	26.1
6.0 x 450	200	300	14.5	99.5	0.61	11.3	3.62	87.9	30.1

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)