



Product Data Sheet

OK 46.30

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

Signed by A-C Thorsson	Approved by Tony Dray/Christos Skodras	Reg no EN005280	Cancelling EN004207	Reg date 2010-10-15	Page 1 (2)
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REASON FOR ISSUE

Classification up dated and AWS data added.

GENERAL

All-round, general purpose rutile electrode for thin and medium thick plates. Good striking and restriking properties, suitable for tack welding. Useful for bridging gaps.

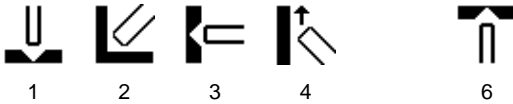
Min AC OCV: 50

Polarity: AC, DC+-

Alloy Type: Carbon manganese

Coating Type: Rutile

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.1 E6013
EN ISO 2560-A E 38 0 R 12

APPROVALS

CE EN 13479

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.05	0.12
Si	0.30	0.70
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

MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO		AWS
	As welded Min	Max	As welded Min
Rp0.2 (MPa)			330
ReL (MPa)	380		
Rm (MPa)	470	600	430
A4 (%)			17
A5 (%)	22		
Charpy V at 0°C (J)	47		



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ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 350	70	100	1.8	92	0.60	93	0.7	58	24	1,2,3,4,6
3.2 x 350	100	140	2.9	95	0.61	57	1.1	60	23	1,2,3,4,6
4.0 x 450	120	170	5.6	94	0.64	27	1.4	96	21	1,2,3,4,6
5.0 x 450	160	250	8.8	96	0.66	17	2.0	105	21	1,2,3,4

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)