OK 55.00 L



OK 55.00 L is a reliable, high-quality, LMA electrode, particularly suitable for welding high strength low-alloy steels. The good, low-temperature impact strength of the weld metal should be noted. The weld metal is also very resistant to hot cracking. Tested according to NACE TM0177 and TM0284

Specifications	
Classifications	SFA/AWS A5.1 : E7018-1H4 R EN ISO 2560-A : E 46 5 B 32 H5
Approvals	ABS : 3YH5 BV : 3Y H5 CE : EN 13479 CWB : E4918-1-H4 DNV : 3Y H5 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+
Diffusible Hydrogen	< 4.0 ml/100g
Alloy Type	Carbon Managnese
Coating Type	Basic covering
Min AC OCV	65 V

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	500 MPa	580 MPa	30 %
ISO			
As Welded	510 MPa	590 MPa	29 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
AWS		
As Welded	-45 °C	130 J
ISO		
As Welded	-45 °C	115 J
As Welded	-50 °C	105 J

Typical Weld Metal Analysis %		
C	**Mn**	**Si**
0.06	1.5	0.5

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 350 mm	80-110 A	22 V	62 %	62 sec	0.81 kg/h
3.15 x 350 mm	110-140 A	23 V	61 %	70 sec	1.17 kg/h
3.15 x 450 mm	110-140 A	24 V	68 %	86 sec	1.4 kg/h
4.0 x 350 mm	140-200 A	23 V	53 %	69 sec	1.84 kg/h
4.0 x 450 mm	140-200 A	24 V	68 %	86 sec	1.89 kg/h

OK 55.00 L

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
5.0 x 450 mm	200-270 A	25 V	69 %	93 sec	2.88 kg/h
6.0 x 450 mm	220-350 A	25 V	75 %	107 sec	5.1 kg/h