

## OK 48.08

Basic universal electrode with very good welding characteristics, especially designed for welding of carbon steels, carbon manganese steels and fine grained carbon manganese steels with elevated yield strength. Typical field of application is offshore construction. The weld metal alloyed with approximately 0.9% Ni fulfills the requirements on impact toughness at -50°C. The coating is of low moisture absorption type and gives diffusible hydrogen < 4ml per 100 grams of weld metal. OK 48.08 is HIC test compliant as per NACE TM0284 & SSC test compliant as per NACE TM0177.

Specifications	
<b>Classifications</b>	SFA/AWS A5.5 : E7018-G H4R EN ISO 2560-A : E 46 5 1Ni B 32 H5
<b>Approvals</b>	ABS : 3Y H5 CE : EN 13479 DB : 10.039.31 DNV-GL : 4 Y40H5 LR : 4Y40 H5 NAKS/HAKC : 2.5-5.0 mm RS : 4Y H5 VdTÜV : 05778

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

<b>Welding Current</b>	AC, DC+(-)
<b>Diffusible Hydrogen</b>	< 4.0 ml/100g
<b>Alloy Type</b>	Low alloyed (0.9 % Ni)
<b>Coating Type</b>	Basic covering

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS</b>			
As welded (3G, V-UP)	530 MPa	610 MPa	
<b>ISO</b>			
As Welded	540 MPa	630 MPa	26 %
PWHT 1 hour(s) 620 °C	480 MPa	550 MPa	26 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
<b>AWS</b>		
As welded (3G, V-UP)	-50 °C	55 J
As welded (3G, V-UP)	-60 °C	50 J
<b>ISO</b>		
As Welded	-50 °C	85 J
As Welded	-60 °C	65 J
PWHT	-46 °C	105 J

Typical Weld Metal Analysis %					
C	Mn	Si	Ni	Cr	Mo
0.06	1.2	0.35	0.95	0.02	0.001

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Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	65-110 A	20 V	60 %	57 sec	0.9 kg/h
3.2 x 350.0 mm	85-150 A	22 V	63 %	63 sec	1.3 kg/h
3.2 x 450.0 mm	85-150 A	22 V	63 %	64 sec	1.3 kg/h
4.0 x 450.0 mm	115-190 A	25 V	66 %	95 sec	1.8 kg/h
5.0 x 450.0 mm	155-280 A	28 V	66 %	93 sec	2.7 kg/h