

OK 46.44

Rutile cellulosic electrode particularly suitable for vertical-down welding. Good ability to bridge gaps.

Specifications	
Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 38 0 RC 11
Approvals	ABS : 2 BV : 2 CE : EN 13479 DB : 10.039.01 DNV : 2 LR : 2 UKCA : EN 13479 VdTÜV : 00674

Welding Current	AC, DC+-
Alloy Type	Carbon Manganese
Coating Type	Rutile-cellulosic covering

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	460 MPa	530 MPa	26 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	0 °C	60 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.07	0.5	0.4

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	70-100 A	26 V	61 %	58 sec	0.78 kg/h
3.2 x 350.0 mm	90-150 A	30 V	51 %	52 sec	1.0 kg/h
4.0 x 350.0 mm	110-200 A	22 V	62 %	62 sec	1.58 kg/h