



Product Data Sheet

OK 46.01

E 'Manual metal-arc welding'
ESAB Perstorp AB Sweden

Prepared by A-C Thorsson	Qualified by P-O Oskarsson	Approved by J-P Ernoult	Reg no EN010619	Cancelling None	Reg date 2023-04-28	Page 1 (2)
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REASON FOR ISSUE

New Product

GENERAL

OK 46.01 is an excellent performing, easy to use, rutile electrode.

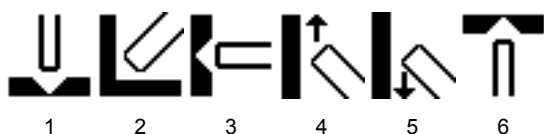
Min AC OCV: 50

Alloy Type: Carbon Manganese

Polarity: AC, DC+-

Coating Type: Rutile-cellulosic covering

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.1 E6013
EN ISO 2560-A E 38 0 RC 11

APPROVALS

CE EN 13479
UKCA EN 13479

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.05	0.12
Si	0.10	0.50
Mn	0.15	0.65
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

Standard	Condition	Rp0.2 [MPa/ksi]		ReL [MPa/ksi]		Rm [MPa/ksi]			A4 [%]		A5 [%]	
		Min	Typ	Min	Typ	Min	Max	Typ	Min	Typ	Min	Typ
ISO	As welded			380/55	400/58	510/74	600/87	510/74			22	28
AWS	As welded	330/48				430/62			17			

Comments:

EN standard requires Rm min 470 MPa and A5 min 20%.

Standard	Condition	Temp [°C/°F]	Charpy V [J/ft-lb]	
			Min	Typ
ISO	As welded	0/32	47/35	70/52

Comments:



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ECONOMICS & CURRENT DATA

Dimension	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
\emptyset x Length 2.5 x 350 mm (0.098 x 13.8 in)	60	100	1,9	87	54	100	3,63 kg/h (8 lb/h)	10	32,8	1,2,3,4,5,6

- W** = Weight (kg / 100 electrodes)
 η = Filler metal efficiency (g weld metal x 100 / g wire)(%)
N = Deposition efficiency (g weld metal x 100 / g electrode)(%)
B = Changes (number of electrodes / kg weld metal)
H = Deposition 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)