

## OK 55.00



OK 55.00 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. The electrode is also suitable for welding high strength ships steel, grades A, D and E.

<b>Approvals</b>	ABS 3Y H5 BV 3Y H5 CE EN 13479 CWB E4918-1-H4 DB 10.039.03 DNV-GL 3Y H5 LR 3Ym H5 NAKS/HAKC 2.5-4.0 mm RS 3Y H5 VdTUV 00632
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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 (< 3 for most of the batches)
<b>Alloy Type</b>	Carbon Manganese
<b>Coating Type</b>	Basic covering

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	500 MPa	590 MPa	28 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As Welded	-45 °C	105 J
As Welded	-50 °C	100 J

### Typical Weld Metal Analysis %

C	Mn	Si
0.06	1.5	0.5

### Current Range

Diameter	Current
2.5 x 350.0 mm	80-110 A
3.2 x 350.0 mm	110-140 A
3.2 x 450.0 mm	110-140 A
4.0 x 350.0 mm	140-200 A
4.0 x 450.0 mm	140-200 A
5.0 x 450.0 mm	200-270 A
6.0 x 450.0 mm	215-360 A