

OK 53.70



A low-hydrogen AC/DC electrode for the one-sided welding of pipes and general structures. The root penetration is good, leaving a flat bead with easily removable slag. The stable arc and the well-balanced slag system make the electrode easy to weld in all positions. Suitable for welding transmission pipelines made from pipe steels up to API 5LX56. It is also suitable for welding the root in higher strength pipes, API 5LX60, 5LX65, 5LX70.

Classifications:	GOST 9467-75:E50A, SFA/AWS A5.1:E7016-1, EN ISO 2560-A:E42 5 B 12 H5
Approvals:	CE EN 13479, ABS 3Y H5, DNV 3Y H5, RS 4Y H5, LR 3Ym H5, ABS E7016-H4

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

Welding Current:	AC, DC (+)
Diffusible Hydrogen:	<5.0 ml/100g
Alloy Type:	Carbon Manganese
Coating Type:	Lime Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	450 MPa	540 MPa	32 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As welded	-45 °C	135 J
As welded	-50 °C	130 J

Typical Weld Metal Analysis %		
C	Mn	Si
0,06	1,1	0,4

Deposition Data						
Diameter	Current	Voltage	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 350 mm	60-85 A	26 V	0.63	87.7	57 s	0.70 kg/h
3.2 x 350 mm	80-130 A	24 V	0.59	54.5	61 s	1.10 kg/h
4.0 x 450 mm	115-190 A	24 V	0.63	24.6	86 s	1.70 kg/h
5.0 x 450 mm	150-250 A	24 V	0.66	15	104 s	2.26 kg/h