

# OK 48.20 (SPL)



## A basic coated, low hydrogen electrode for MMAW

Classification AWS A5.1:E 7018



### DESCRIPTION

OK 48.20(Spl) is a basic coated low hydrogen, all position electrode for welding medium tensile & fine grained carbon steels. The electrode gives an extremely smooth arc, least spatter with good slag detachability. The weldmetal is of highest radiographic soundness with good mechanical properties and excellent impact strength. The electrode gives deposition efficiency of approx.115%.

### TYPICAL APPLICATIONS

OK 48.20(Spl) is especially designed for welding of C-Mn steels such as ASTM A 106 Gr B, pipelines, etc. used for sour gas service.

**WELDING CURRENT:** DC+, AC, 70V

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.06	Mn	1.15	YS	510 N/mm <sup>2</sup>
Si	0.50	S	0.008	UTS	590 N/mm <sup>2</sup>
P	0.010			EL (L=5d)	26%
				Impact (CVN) at -30°C	80J

**PASSES CORROSION TEST AS PER NACE STANDARD TM-01-77 AND TM-02-84** (of NACE MR 0175 specification).

Guaranteed Stress Value after SSCC Test: 357 Mpa

Hardness of the weldmetal: 22 RC max

### CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	75-110	130	520
3.15	450	105-150	90	360
4.00	450	140-200	60	240
5.00	450	190-270	40	160

**PACKING:** Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box.