P 48K

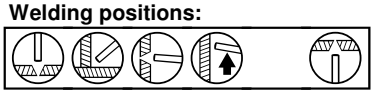
SMAW - (Stick) - MMA

Low-alloyed

Date: 2013-05-30
Revision: 22

Description:
P 48K is a basic-coated low hydrogen electrode producing a 2.5 % Ni weld metal. The all-positional electrode is designed for applications demanding high yield strength and excellent fracture toughness at temperatures down to -60 °C, both in the as welded and stress relieved condition, and is suitable for offshore fabrication and LPG work.
P 48K is CTOD tested

Welding positions:



Coating type:
Basic

Welding current:
DC+/-, AC OCV ≥ 70 V

Hydrogen content / 100 g weld metal
≤ 5 ml

Metal recovery:
120%

Redrying temperature:
350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,30	0,70				2,0
Typical	0,05	0,5	0,8	0,01	0,005		2,4
Max	0,09	0,60	1,25	0,015	0,015	0,1	2,6

	Mo	Cu	V	Nb
Min				
Typical				
Max	0,1	0,2	0,05	0,05

Mechanical properties

	Specified	Typical
Yield strength, Re:	≥ 460 MPa	530 MPa
Tensile Strength, Rm:	550-650 MPa	620 MPa
Elongation, A5	≥ 22%	25%
Impact energy, CV:	-60 °C • ≥ 47 J	-60 °C • 90 J

Classification:

EN ISO 2560-A	E 46 6 2Ni B 32 H5
AWS A5.5	E8018-C1

Approvals:

CE	
LR	3m, 5Y42m H5
ABS	3Y
BV	5Y40
DNV	5Y H5
MRS	5Y 42 H5

Note

Core wire:
S ≤ 0.015%
P ≤ 0.015%
N ≤ 0.008%

Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,5	350	71582500	80-110	24	0,64	63	0,9	64
3,2	450	71583200	110-150	25	0,67	33	1,3	84
4,0	450	71584000	140-200	27	0,7	22	1,9	88
5,0	450	71585000	200-270	27	0,71	13	2,6	95