



Product Data Sheet

OK GoldRox

E 'Manual metal-arc welding'
ESAB-MÓR Kft Hungary

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
J-P Ernoult	P-O Oskarsson	J-P Ernoult	EN009137	EN009133	2020-04-01	1 (2)

REASON FOR ISSUE

New Product.

GENERAL

OK GoldRox is a true all-round and all-position rutile electrode. With exceptional arc stability and reduced spatter for decreased cleaning time, start and restart properties that allow for easy tack welds, and brilliant slag removal, novice and experienced welders can rely on OK GoldRox. Available in different package sizes – all fully recyclable – to make sure each pack fits specific job requirements.

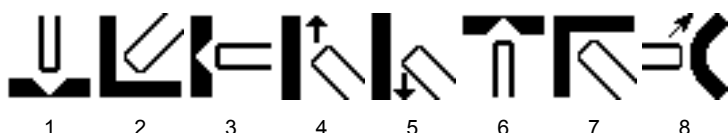
Min AC OCV: 50 V

Alloy Type: Carbon Manganese

Polarity: DC+/-, AC

Coating Type: Rutile-cellulosic covering

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.1 E6013
EN ISO 2560-A E 42 0 RC 11

APPROVALS

ABS 2
BV 2
CE EN 13479
DB 10.039.48
DNV-GL 2
LR 2
VdTÜV 19622

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.05	0.11
Si	0.30	0.70
Mn	0.40	0.80
P		0.030
S		0.030
Cr		0.19
Ni		0.29
Mo		0.19
V		0.049



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MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO			AWS
	As welded Min	Max	Typ	As welded Min
Rp0.2 (MPa)				330
ReL (MPa)	420		460	
Rm (MPa)	510	640	520	430
A4 (%)				17
A5 (%)	22		23	
Charpy V at 0°C (J)	47		60	
	Comments: EN standard requires Rm min 500 MPa and A5 min 20%			Comments:

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U	Welding Positions
$\emptyset$ x Length	Min	Max								
2.0 x 300	50	70	1.0	93	0.60	172	0.55	38	25	1,2,3,4,5,6,7,8
2.5 x 350	60	90	1.8	94	0.62	91	0.8	49	25	1,2,3,4,5,6,7,8
3.2 x 350	90	140	2.9	93	0.59	59	1.1	57	24	1,2,3,4,5,6,7,8
4.0 x 350	110	185	4.4	88	0.58	40	1.4	64	26	1,2,3,4,5,6,7,8

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit 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)