

OK GoldRox

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.

Classifications	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

Welding Current	DC+, AC
Alloy Type	Carbon Manganese
Coating Type	Rutile-cellulosic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	460 MPa	520 MPa	23 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	0 °C	60 J

Typical Weld Metal Analysis %

C	Mn	Si
0.08	0.45	0.40

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.0 x 300.0 mm	50-70 A	25 V	60 %	172	38 sec	0.55 kg/h
2.5 x 350.0 mm	60-90 A	25 V	62 %	91	49 sec	0.8 kg/h
3.0 x 350.0 mm	90-140 A	26 V	59 %	65	52 sec	1.06 kg/h
3.2 x 350.0 mm	90-140 A	24 V	59 %	59	57 sec	1.1 kg/h
4.0 x 350.0 mm	110-185 A	26 V	58 %	40	64 sec	1.4 kg/h