

# Omnia<sup>®</sup> 46

## Key Features

- Rutile general purpose, all positions electrode
- Very suitable for low open circuit voltage transformers (min. OCV 42 V)
- Outstanding weldability
- Premium electrode Made in Europe

## Conformances

<b>AWS A5.1:</b>	E6013
<b>AS/NZS 4855-A:</b>	E 42 0 R 11
<b>AS/NZS 4855-B:</b>	E 4912 A
<b>ABS, BV, DNV-GL, LR:</b>	2

## Typical Applications

- Applicable for “clean” structural steel (2.0, 2.5, 3.2 mm)
- Smaller diameters excellent for hobby market

## Welding Positions



## Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	609060	CB 4.8 kg (3 x CB per carton)
2.5	350	609070	Linc Pack 1.0kg
3.2	350	609061	CB 5.3 kg (3 x CB per carton)
4.0	450	609064	CB 5.9 kg (3 x CB per carton)
5.0	450	609065	CB 5.8 kg (3 x CB per carton)

## Mechanical Properties

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ 0°C
<b>Requirements - AWS</b>	330 min	430 min	17 min	Not specified
<b>Requirements - AS/NZS</b>	380 min	470-600	20 min	Min 47
<b>Typical Results - As Welded</b>	460	540	27	65

## Deposit Composition

	%C	%Mn	%Si
<b>Typical Results - As Welded</b>	0.06	0.5	0.45

## Typical Operation Procedures

Polarity	Current (amps)	
	2.5mm	3.2mm
AC / DC-	70-90	90-125

## Welding Parameters, Optimum Fill Passes

Diameter mm	Welding Positions							
	PA/1G	PB/2F	PC/2G	PF/3G up	PG/3G down	PE/4G	PH/5G up	PJ/5G down
2.5	80A	85A	85A	80A	85A	85A	80A	85A
3.2	110A	115A	115A	110A	115A	110A	110A	115A