

OK Femax 33.80

High-recovery rutile electrode for high productivity welding of fillets in the horizontal-vertical position. Particularly suitable for welding thick plates and for long run-out lengths. Good bead appearance. Easy slag removal.

Specifications	
Classifications	SFA/AWS A5.1 : E7024 EN ISO 2560-A : E 42 0 RR 73
Approvals	ABS : 2Y ABS : E7024 BV : 2Y CE : EN 13479 CWB : E4924 DB : 10.039.28 DNV-GL : 2Y LR : 2Y PRS : 2Y RINA : 2Y RS : 2Y VdTÜV : 00634

Approvals are based on factory location. Please contact ESAB for more information.

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

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	460 MPa (66.7 ksi)	550 MPa (79.8 ksi)	27 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	0 °C (32 °F)	60 J (44 ft-lb)

Typical Weld Metal Analysis %		
C	Mn	Si
0.09	0.7	0.4

Deposition Data						
Diameter	Current	Voltage	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Burn-off Time /Electrode	Deposition Rate
3.2 x 450 mm (1/8 x 18 in.)	130-170 A	28 V	0.68	21.0	69 sec	2.50 kg/h (5.5 lbs/h)
4.0 x 450 mm (5/32 x 18 in.)	180-230 A	30 V	0.68	13.5	69 sec	3.80 kg/h (8.4 lbs/h)
5.0 x 450 mm (3/16 x 18 in.)	250-340 A	30 V	0.67	9.1	68 sec	5.80 kg/h (12.8 lbs/h)
6.0 x 450 mm (1/4 x 18 in.)	300-430 A	35 V	0.68	6.4	79 sec	7.1 kg/h (15.6 lbs/h)