

OK Femax 38.65

High-recovery zircon-basic electrode, especially developed for making butt welds and fillet welds in the flat position in carbon steels, carbon manganese steels and fine-grained manganese steels with elevated yield strength. Good slag removal.

Specifications	
Classifications	SFA/AWS A5.1 : E7028 EN ISO 2560-A : E 42 4 B 73 H5
Approvals	ABS : E7028 ABS : 3Y H5 BV : 3Y H5 CE : EN 13479 DB : 10.039.15 DNV-GL : 3 YH5 LR : 3Y H5 PRS : 3Y H5 VdTUV : 00635

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

Welding Current	AC, DC+
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	440 MPa	550 MPa	28 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-20 °C	100 J
As Welded	-40 °C	85 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.08	1.1	0.4

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
4.0 x 450.0 mm	170-240 A	36 V	68 %	70 sec	3.7 kg/h
5.0 x 450.0 mm	225-355 A	40 V	69 %	72 sec	5.7 kg/h
6.0 x 450.0 mm	300-430 A	40 V	68 %	80 sec	7.2 kg/h