

OK Femax 38.85

Very fast rutile-basic, high-recovery electrode. The electrode is especially suitable for welding horizontal-vertical fillets, where a large throat thickness is required. It welds best on AC.

Specifications	
Classifications	SFA/AWS A5.1 : E7028 EN ISO 2560-A : E 42 3 RB 73 H10
Approvals	ABS : 3YH5 BV : 3YH10 DNV : 3YH10 RS : 3YH10 Seproz : UNA 272581

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

Welding Current	AC, DC +
Diffusible Hydrogen	<8.0 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Rutile Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	480 MPa	560 MPa	29 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	-30 °C	80 J
As Welded	-20 °C	100 J

Deposition Data						
Diameter	Current	Voltage	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
5.0 x 450 mm	200-350 A	40 V	0.70	7.0	84 sec	6.00 kg/h