

OK Femax 33.30

High-recovery rutile electrode for the 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 53
Approvals	CE : EN 13479 DB : 10.039.26 DNV : 2 VdTÜV : 00972

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

Welding Current	AC, DC+-
Alloy Type	Carbon Steel
Coating Type	Rutile

Typical Tensile Properties		
Yield Strength	Tensile Strength	Elongation
ISO		

Typical Charpy V-Notch Properties	
Condition	Testing Temperature
ISO	
As Welded	0 °C
As Welded	-20 °C

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
3.2 x 450 mm	130-150 A	23 V	0.6	28	87 sec	1.5 kg/h
4.0 x 450 mm	150-220 A	26 V	0.6	18	83 sec	2.4 kg/h
5.0 x 450 mm	220-270 A	26 V	0.6	12	102 sec	3.1 kg/h