

OK Femax 33.60

High-recovery rutile electrode particularly suitable for horizontal- vertical fillet welding of thin and medium thick plates. Suitable for long run-out lengths.

Specifications	
Classifications	SFA/AWS A5.1 : E7024 EN ISO 2560-A : E 42 0 RR 53
Approvals	CE : EN 13479 DB : 10.039.11 DNV-GL : 2 VdTÜV : 01030

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 Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	0 °C	60 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.07	0.7	0.4

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 450.0 mm	130-170 A	30 V	68 %	71 sec	2.2 kg/h
4.0 x 450.0 mm	150-230 A	33 V	68 %	77 sec	3.1 kg/h
5.0 x 450.0 mm	200-350 A	35 V	68 %	78 sec	4.9 kg/h
6.0 x 450.0 mm	280-450 A	36 V	68 %	83 sec	6.4 kg/h