

OK Femax 33.81

OK Femax 33.81 is a high recovery electrode for high productivity welding of fillets in the horizontal-vertical position. Particular well suited for welding thick plates and for long run out lengths. Restrikes even on cold crater. Easy slag removal.

Specifications

Classifications	SFA/AWS A5.1 : E7024 EN ISO 2560-A : E 42 0 RR 73
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	480 MPa	560 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	0 °C	50 J
As Welded	-20 °C	28 J

Deposition Data

Diameter	Current	Voltage	Efficiency (%)
3.2 mm	140-170 A	28 V	180 %
4 mm	180-230 A	31 V	180 %
4.5 mm	250-300 A	32 V	180 %
5 mm	250-350 A	34 V	180 %
6 mm	300-430 A	37 V	180 %