OK Femax 38.95

High-recovery, iron powder electrode, giving approximately 240% recovery. OK 38.95 gives a welding speed comparable to submerged-arc welding: up to 240g of weld metal /minute with 6.0mm electrode. Primarily designed for welding butt and fillet joints in the flat position where it gives a smooth transition to the base material. For welding of carbon steels, carbon manganese steels and fine-grained carbon manganese steels with elevated yield strength.

Specifications	
Classifications	SFA/AWS A5.1 : E7028 EN ISO 2560-A : E 38 4 B 73 H10
Approvals	ABS : 3Y H10 BV : 3Y H10 DNV-GL : 3 YH10 LR : 3Y H10

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	Zircon Basic

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
4.0 x 450.0 mm	170-240 A	35 V	67 %	67 sec	3.6 kg/h
5.0 x 450.0 mm	330-400 A	40 V	70 %	63 sec	9.0 kg/h
6.0 x 450.0 mm	400-520 A	50 V	71 %	65 sec	13.3 kg/h