

OK Femax 39.50

Very fast, high recovery acid electrode for horizontal-vertical fillets, lap and butt joints in mild steels. The electrode gives excellent profile with good ,easy removeable slag. Tolerates a wide range of run-out lengths.

Specifications	
Classifications	SFA/AWS A5.1 : E7027 EN ISO 2560-A : E 42 2 RA 53
Approvals	ABS : 3Y BV : 3Y CE : EN 13479 DB : 10.039.07 DNV-GL : 3 Y LR : 3Y PRS : 3 VdTÜV : 00636

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

Welding Current	AC, DC+-
Alloy Type	Carbon Manganese
Coating Type	Rutile-acid covering

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	430 MPa	520 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	-30 °C	55 J
As Welded	-20 °C	65 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.07	0.7	0.3

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	31 V	68 %	69 sec	2.3 kg/h
4.0 x 450.0 mm	150-230 A	32 V	70 %	71 sec	3.2 kg/h
5.0 x 450.0 mm	200-350 A	37 V	70 %	65 sec	5.5 kg/h
6.0 x 450.0 mm	280-400 A	35 V	71 %	86 sec	6.4 kg/h