

OK 33.80

Rutile coated electrode designed for welding on flat position by the "contact" system on butt or filled joints; large amount of iron dust in coating, easy striking, high weld speed, beautiful finishing, high productivity.

Specifications	
Classifications	SFA/AWS A5.1 : E7024
Approvals	ABS : 2Y BV : 2, 2Y DNV : 2 FBTS : E7024 LR : 2m, 2Ym NO

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

Welding Current	DC+-, AC
Alloy Type	CMn
Coating Type	Rutile

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	520 MPa	590 MPa	26 %

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
3.2 x 450.0 mm	130-170 A	34 V	67 %	67 sec	2.2 kg/h
4.0 x 350.0 mm	140-230 A				0.0 kg/h
4.0 x 450.0 mm	140-230 A	36 V	68 %	71 sec	3.0 kg/h
5.0 x 350.0 mm	210-350 A				0.0 kg/h
5.0 x 450.0 mm	210-350 A	39 V	62 %	72 sec	4.3 kg/h
5.0 x 700.0 mm	210-430 A	40 V	71 %	155 sec	3.8 kg/h
6.0 x 450.0 mm	270-430 A	41 V	70 %	74 sec	6.3 kg/h
6.0 x 700.0 mm	270-430 A	40 V	68 %	160 sec	4.8 kg/h