

OK Femax 33.80

High-recovery rutile electrode for high productivity welding of fillets in the horizontal-vertical position. Particularly suitable for welding thick plates and for long run-out lengths. Good bead appearance. Easy slag removal.

Classifications	SFA/AWS A5.1 : E7024 EN ISO 2560-A : E 42 0 RR 73
Approvals	ABS : 2Y ABS : E7024 BV : 2Y CE : EN 13479 CWB : E4924 DB : 10.039.28 DNV-GL : 2Y LR : 2Y PRS : 2Y RINA : 2Y RS : 2Y VdTÜV : 00634

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	460 MPa	550 MPa	27 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	0 °C	60 J

Typical Weld Metal Analysis %

C	Mn	Si
0.09	0.7	0.4

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 450.0 mm	130-170 A	28 V	68 %	21.0	69 sec	2.5 kg/h
4.0 x 450.0 mm	180-230 A	30 V	68 %	13.5	69 sec	3.8 kg/h
5.0 x 450.0 mm	250-340 A	30 V	67 %	9.1	68 sec	5.8 kg/h
6.0 x 450.0 mm	300-430 A	35 V	68 %	6.4	79 sec	7.1 kg/h