



Product Data Sheet

OK Femax 33.60

E 'Manual metal-arc welding'
ESAB Perstorp AB Sweden

Prepared by A-C Thorsson	Qualified by Tero Borg	Approved by J-P Ernoult	Reg no EN007220	Cancelling EN007142	Reg date 2016-05-09	Page 1 (2)
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REASON FOR ISSUE

DNV-GL approval.

GENERAL

High-recovery rutile electrode particularly suitable for horizontal- vertical fillet welding of thin and medium thick plates. Suitable for long run-out lengths.

Min AC OCV: 50

Polarity: AC, DC+(-)

Alloy Type: Carbon steel

Coating Type: Rutile

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.1 E7024
EN ISO 2560-A E 42 0 RR 53

APPROVALS

ABS 2
CE EN 13479
DB 10.039.11
DNV-GL 2
VdTÜV 01030

APPROVALS (SPECIFIC)

Seproz UNA 272581

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C		0.12
Si	0.20	0.60
Mn	0.45	0.95
P		0.030
S		0.020
Cr		0.19
Ni		0.29
Mo		0.19
V		0.049
Nb		0.049
Cu		0.29



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MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO			AWS
	As welded Min	Max	Typ	As welded Min
Rp0.2 (MPa)				400
ReL	420		460	
Rm (MPa)	510	640	540	490
A4 (%)				17
A5 (%)	22		27	
Charpy V at 0°C (J)	47		60	
Charpy V at -10°C (J)	47			
	Comments: EN standard requires Rm min 500 Mpa and A5 Min 20%.			Comments:

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U	Welding Positions
\varnothing x Length	Min	Max								
3.2 x 450	130	170	6.4	160	0.68	23.0	2.20	71	30	1,2
4.0 x 450	150	230	9.1	160	0.68	15.0	3.10	77	33	1,2
5.0 x 450	200	350	15.5	160	0.68	9.5	4.90	78	35	1,2
6.0 x 450	280	450	21.7	160	0.68	6.4	6.40	83	36	1,2

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)