



# Product Data Sheet

E 'Manual metal-arc welding'

## OK Femax 33.60

Signed by P-O Oskarsson	Approved by Tony Dray/Christos Skodras	Reg no EN004433	Cancelling EN003368	Reg date 2008-07-14	Page 1 (2)
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### REASON FOR ISSUE

Sepros added

### 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  
BV                    2  
CE                    EN 13479  
DB                    10.039.11  
DNV                   2  
GL                    2  
LR                    2  
VdTÜV                01030

### APPROVALS (SPECIFIC)

Seproz                UNA 054403

### 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



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## MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	ISO	
	As welded	
	Min	Typ
Rp0.2 (MPa)	420	450
Rm (MPa)	510	550
A4-A5 (%)	25	28
Charpy V at 0°C (J)	47	55
Charpy V at -20°C (J)	28	

## ECONOMICS & CURRENT DATA

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

**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)