

# OK Femax 33.60 SMAW

Type Rutile

E7024

## Description

OK Femax 33.60 is a high-recovery, rutile, iron powder electrode giving a metal recovery of about 160%. OK Femax 33.60 is particularly recommended for welding horizontal-vertical fillets. The weld metal stays well on the vertical leg and gives a good transition to the base material without undercutting, even at high welding currents.

## Recovery

160%

## Welding current

AC, DC+(-) OCV 50 V



## Classifications

|              |                    |
|--------------|--------------------|
| SFA/AWS A5.1 | E7024              |
| CSN 05 5010  | E 51.21            |
| DIN 1913     | E 51 32 RR 11 160  |
| EN 499       | E 42 0 RR 53       |
| ISO 2560     | E 51 2 RR 160 31   |
| NF A 81-309  | E 51 3/2 RR 160 31 |
| UNE 14.003   | E 51 32 RR 160 31  |

## Typical all weld metal composition, %

| C     | Si  | Mn  |
|-------|-----|-----|
| <0.12 | 0.4 | 0.7 |

## Typical mech. properties all weld metal

|                       |     |
|-----------------------|-----|
| Yield stress, MPa     | 450 |
| Tensile strength, MPa | 550 |
| Elongation, %         | 28  |

## Charpy V

| Test temps, °C | Impact values, J |
|----------------|------------------|
| 0              | 55               |

## Approvals

|        |           |
|--------|-----------|
| ABS    | 2         |
| BV     | 2         |
| DB     | 10.039.11 |
| DNV    | 2         |
| DS     | EN 499    |
| GL     | 2         |
| LR     | 2         |
| RINA   |           |
| SS     | EN 499    |
| UDT    | EN 499    |
| Ü      | 10.039/1  |
| VdTÜV  | 01030     |
| SZ 202 | (**)      |

## Welding parameters

| Diameter, mm | Length, mm | Welding current, A | Arc voltage, V | N.<br>Kg weld metal/kg electrodes | B.<br>No. of electrodes/kg weld metal | H.<br>Kg weld metal/hour arc time | T.<br>Burn-off time, s/ electrode |
|--------------|------------|--------------------|----------------|-----------------------------------|---------------------------------------|-----------------------------------|-----------------------------------|
| 2.5          | 350        | 85-125             | 27             | 0.64                              | 53.0                                  | 1.6                               | 43                                |
| 3.2          | 450        | 130-170            | 30             | 0.68                              | 23.0                                  | 2.2                               | 71                                |
| 4.0          | 450        | 150-230            | 33             | 0.68                              | 15.0                                  | 3.1                               | 77                                |
| 5.0          | 450        | 200-350            | 35             | 0.68                              | 9.5                                   | 4.9                               | 78                                |
| 6.0          | 450        | 280-450            | 36             | 0.68                              | 6.4                                   | 6.4                               | 83                                |