

OK Femax 33.80 SMAW

Type Rutile E7024

Description

High-recovery rutile electrode for the 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.

Recovery

180%

Welding current

AC, DC(+ -) OCV 50 V



Classifications

SFA/AWS A5.1	E7024
EN 499	E 42 0 RR 73
ISO 2560	E 51 2 RR 180 31
NF A 81-309	E 51 3/2 RR 190 31

Typical all weld metal composition, %

C	Si	Mn
<0.12	0.5	0.7

Typical mech. properties all weld metal

Yield stress, MPa	450
Tensile strength, MPa	550
Elongation, %	26

Charpy V

Test temps, °C	Impact values, J
0	50

Approvals

ABS	2	RS	2
BV	2	Sepros	UNA 485154
CL	EN499	SFS	EN 499
DB	10.039.28	SS	EN 499
DNV	2	UDT	EN 499
DS	EN 499	Ü	10.039/1
DSRK	44.2	VdTUV	00634
	(FEMATIC too)		
GL	2Y		
LR	2, 2Y		
PRS	2		

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.5	350	85-125	27	0.64	53.0	1.6	43
3.2	450	130-170	28	0.68	21.0	2.5	69
4.0	450	180-230	30	0.68	13.5	3.8	69
4.5	700	180-230	30	0.69	6.8	3.7	141
5.0	450	250-340	30	0.67	9.1	5.8	68
5.0	700	210-260	31	0.69	5.6	4.4	146
5.6	700	250-300	35	0.69	4.7	4.5	171
6.0	450	300-430	35	0.68	6.4	7.1	79
6.0	700	280-400	34	0.72	4.0	6.9	131

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