



**NEW**

## 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.

- Rutile Type High Iron Powder Electrode.
- High Productivity Fillet and Butt Welding in all down-hand positions.
- Self-releasing slag.

Slag lift and “side wall” wash at weld toes are superb and welding speeds are approximately double those of conventional electrodes of equal size and length.

OK Femax 33.80 is recommended for high production welding where large standing fillet welds are required. It is the ideal electrode for heavy structural welding applications such as tanks, frames, girders and beams, ship structures and rolling stock and general fabrication in the workshop or on-site.



**E7024**

### CLASSIFICATIONS

SFA/AWS A5.1 E7024

ISO 2560-A : E 42 0 RR 73

ISO 2560-B: E4924 A

### APPROVALS\*

ABS 2Y LR 2Ym

ABS E7024 PRS 2

BV 2Y RS 2Y

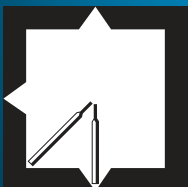
CE EN 13479 DB 10.039.28

CWB CSA W48: E4924 DNV 2Y

Seproz UNA 272581 GL 2Y

VdTÜV 00634

Part No.	Description	Packs/ Carton	Carton	Current
3380324000	OK Femax 33.80 3.2x450mm	3 x 6.2kg	18.6kg	130-170
3380404000	OK Femax 33.80 4.0x450mm	3 x 5.9kg	17.7kg	180-230
3380504000	OK Femax 33.80 5.0x450mm	3 x 5.4kg	16.2kg	250-340
3380604000	OK Femax 33.80 6.0x450mm	3 x 5.7kg	17.1kg	300-430



All down-hand  
welding positions

**PRODUCT INFORMATION**

Product / Tradename	OK Femax 33.80	Certificate No.	08148
Standard / Classification	AS/NZS 4855: E 4924 A SFA/AWS A5.1: E7024	Date	01/09/20
		Batch No.	
		Part Numbers	3380324000/ 3380404000/ 3380504000/ 3380604000
Sizes	3.2, 4.0, 5.0, 6.0 mm	Consumable Type	Electrode
		Country of Origin	Europe

**[2.2] - TYPICAL CHEMICAL ANALYSIS**

TYPICAL DATA: ACC TO EN 10204 2.2

C	Mn	Si	P	S	Ni	Cr	Mo	V	Cu	Nb	Ti	Al	B	Zr
0.09	0.7	0.4												

Notes

**[2.2] - TYPICAL MECHANICAL PROPERTIES**

TYPICAL DATA: ACC TO EN 10204 2.2

**TENSILE PROPERTIES**

Condition	Shielding	Test Temp	R <sub>p</sub> 0.2% 0.2% Yield	R <sub>m</sub> UTS	A <sub>5</sub> Elongation
		Ambient	460 MPa	550 MPa	27%

**IMPACT PROPERTIES**

TYPICAL DATA: ACC TO EN 10204 2.2

Temp	Impact Value	Lateral Expansion
0	60 J avg.	

**OTHER MECHANICAL PROPERTIES - TYPICAL AVG.**

Hardness

**OTHER PROPERTIES / INFORMATION**

Diffusible Hydrogen (typical) ml H/100g weld metal	Radiographic Soundness
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**COMPLIANCE**

Cigweld Pty. Ltd. certifies that the material listed in the certificate conforms to the listed specifications and this product is supplied under a QA Program fulfilling the EN ISO 9001 standard

This certificate is produced electronically and is valid without signature.

Issued by  
**Vida Mokhtar**  
 Quality Manager

Reviewed by  
**Damian Bibby**  
 Senior Brand Manager - Consumables

**Company Details**

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