



Product Data Sheet

OK Femax 39.50

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

Prepared by P-O Oskarsson	Qualified by Tero Borg	Approved by J-P Ernoult	Reg no EN007333	Cancelling EN007029	Reg date 2016-07-28	Page 1 (2)
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REASON FOR ISSUE

Alloy and coating type amended. DNV-GL approval.

GENERAL

Very fast, high recovery acid electrode for horizontal-vertical fillets, lap and butt joints in mild steels. The electrode gives excellent profile with good ,easy removeable slag. Tolerates a wide range of run-out lengths.

Min AC OCV: 65

Polarity: AC, DC+-

Alloy Type: Carbon Manganese

Coating Type: Rutile-acid covering

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.1 E7027
EN ISO 2560-A E 42 2 RA 53

APPROVALS

ABS 3Y
BV 3Y
CE EN 13479
DB 10.039.07
DNV-GL 3 Y
LR 3Ym
PRS 3
VdTÜV 00636

APPROVALS (SPECIFIC)

Seproz UNA 272581

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.07	0.12
Si	0.10	0.40
Mn	0.50	1.00
P		0.030
S		0.030



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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 (MPa)	420		430	
Rm (MPa)	510	640	520	490
A4 (%)				22
A5 (%)	22		28	
Charpy V at -20°C (J)	47		65	
Charpy V at -30°C (J)			55	27
	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
Ø x Length	Min	Max								
3.2 x 450	130	170	6.6	170	0.68	22.6	2.3	69	31	1,2
4.0 x 450	150	230	9.2	163	0.70	15.6	3.2	71	32	1,2
5.0 x 450	200	350	14.2	161	0.70	10.1	5.5	65	37	1,2
6.0 x 450	280	400	21.6	171	0.71	6.6	6.4	86	35	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)