



# Product Data Sheet

# OK 43.33

E 'Manual metal-arc welding'  
ESAB-MÓR Kft Hungary

|                              |                               |                            |                    |                        |                        |               |
|------------------------------|-------------------------------|----------------------------|--------------------|------------------------|------------------------|---------------|
| Prepared by<br>P-O Oskarsson | Qualified by<br>P-O Oskarsson | Approved by<br>J-P Ernoult | Reg no<br>EN007465 | Cancelling<br>EN006905 | Reg date<br>2017-02-10 | Page<br>1 (2) |
|------------------------------|-------------------------------|----------------------------|--------------------|------------------------|------------------------|---------------|

## REASON FOR ISSUE

New formulation - Improved product.

## GENERAL

This electrode is easy to weld and has a easy removable slag. The most suitable welding position for this electrode is the flat position. The good flowing properties of the weldmetal give a good finish of the weld-beds both on butt and fillet weld. The stable arc also on low currents makes this electrode suitable for welding sheet metal.

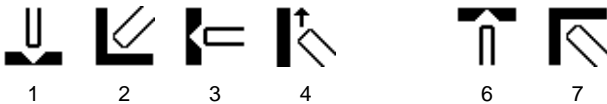
**Min AC OCV:** 50

**Polarity:** AC, DC+-

**Alloy Type:** Carbon Manganese

**Coating Type:** Rutile thick covering

## WELDING POSITIONS



## CLASSIFICATIONS Electrode

SFA/AWS A5.1      E6013  
 EN ISO 2560-A    E 42 0 RR 12

## APPROVALS

CE                      EN 13479

## CHEMICAL COMPOSITION

### All Weld Metal (%)

|    | Min  | Max   |
|----|------|-------|
| C  |      | 0.12  |
| Si | 0.35 | 0.75  |
| Mn | 0.25 | 0.75  |
| P  |      | 0.030 |
| S  |      | 0.030 |
| Cr |      | 0.19  |
| Ni |      | 0.29  |
| Mo |      | 0.19  |
| V  |      | 0.049 |
| Nb |      | 0.049 |
| Cu |      | 0.29  |

## MECHANICAL PROPERTIES OF WELD METAL

| Properties          | ISO              |     | AWS              |
|---------------------|------------------|-----|------------------|
|                     | As welded<br>Min | Max | As welded<br>Min |
| Rp0.2 (MPa)         |                  |     | 330              |
| ReL (MPa)           | 420              |     |                  |
| Rm (MPa)            | 500              | 640 | 430              |
| A4 (%)              |                  |     | 17               |
| A5 (%)              | 20               |     |                  |
| Charpy V at 0°C (J) | 47               |     |                  |



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## ECONOMICS & CURRENT DATA

| Dimension (mm)<br>Ø x Length | Current (A) |     | W   | η  | N    | B   | H   | T  | U  | Welding<br>Positions |
|------------------------------|-------------|-----|-----|----|------|-----|-----|----|----|----------------------|
|                              | Min         | Max |     |    |      |     |     |    |    |                      |
| 2.5 x 300                    | 50          | 110 | 1.8 | 94 | 0.54 | 108 | 0.8 | 42 | 25 | 1,2,3,4,6,7          |
| 2.5 x 350                    | 50          | 110 | 2.0 | 94 | 0.54 | 88  | 0.9 | 46 | 25 | 1,2,3,4,6,7          |
| 3.2 x 350                    | 80          | 150 | 3.6 | 97 | 0.57 | 51  | 1.3 | 57 | 26 | 1,2,3,4,6,7          |
| 4.0 x 450                    | 120         | 210 | 7.3 | 97 | 0.54 | 27  | 1.9 | 76 | 27 | 1,2,3,4,6,7          |

**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)