

Filarc 56S



Basic, thin-coated AC/DC electrode providing excellent mechanical properties. The electrode ensures fully penetrated root passes, even under adverse conditions. Low moisture content coating and high resistance to moisture re-absorption. The electrode is CTOD tested.

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|------------------------|--|
| Classifications | SFA/AWS A5.1 : E7016-1 H4 R EN ISO 2560-A : E 42 5 B 1 2 H5 |
| Approvals | ABS 3YH5 BV 3YH5 CE EN 13479 DB 10.105.15 DNV-GL 4 YH5 LR 4Y40H5 VdTUV 03012 RS 4Y42H5 Seproz UNA 272581 |

Approvals are based on factory location. Please contact ESAB for more information.

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|----------------------------|------------------|
| Welding Current | AC, DC+(-) |
| Diffusible Hydrogen | < 4.0 ml/100g |
| Alloy Type | Carbon manganese |
| Coating Type | Basic covering |

Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|------------|----------------|------------------|------------|
| ISO | | | |
| As Welded | 470 MPa | 550 MPa | 30 % |

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|------------|---------------------|--------------|
| ISO | | |
| As Welded | -45 °C | 150 J |
| As Welded | -50 °C | 140 J |

Typical Weld Metal Analysis %

| C | Mn | Si |
|------|-----|-----|
| 0.06 | 1.3 | 0.4 |

Deposition Data

| Diameter | Current | Voltage | Number of electrodes/ kg weld metal | Fusion time per electrode at 90% I max | Deposition Efficiency % | Deposition Rate @ 90% I max |
|----------------|-----------|---------|--|--|----------------------------|--------------------------------|
| 2.5 x 350.0 mm | 55-85 A | 22 V | 90.0 | 50 sec | 58 % | 0.8 kg/h |
| 3.2 x 350.0 mm | 80-140 A | 22 V | 52.0 | 53 sec | 61 % | 1.3 kg/h |
| 3.2 x 450.0 mm | 80-130 A | 22 V | 41.0 | 73 sec | 61 % | 1.2 kg/h |
| 4.0 x 350.0 mm | 110-180 A | 22 V | 34.0 | 62 sec | 64 % | 1.7 kg/h |
| 4.0 x 450.0 mm | 110-170 A | 22 V | 26.0 | 83 sec | 65 % | 1.7 kg/h |
| 5.0 x 450.0 mm | 180-230 A | 22 V | 17.0 | 90 sec | 66 % | 2.4 kg/h |