

FILARC Product Data Sheet

FILARC 75S

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

Prepared by A-C Thorsson	Qualified by Tero Borg	Approved by J-P Ernoult	Reg no EN007068	Cancelling EN006767	Reg date 2016-02-16	Page 1 (2)
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REASON FOR ISSUE

Typical mechanical values added.

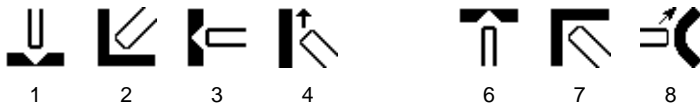
GENERAL

CTOD-tested, all-positional basic 115% recovery electrode for 50D steels in offshore fabrication. Alloyed with 2.5% nickel. Good CVN toughness down to -60°C. CTOD tested in the AW and SR conditions. Use short arc, weaving slightly where permitted. Use DC- for root runs.

Min AC OCV: 65
Polarity: DC+-, AC

Alloy Type: C, Mn, 2.5% Ni
Coating Type: Basic

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.5 E8018-C1
EN ISO 2560-A E 46 6 2Ni B 32 H5

APPROVALS

ABS 3Y H5
CE EN 13479
LR 5Y42 H5

APPROVALS (SPECIFIC)

Sepro UNA 272581

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.03	0.08
Si	0.20	0.50
Mn	0.60	1.10
P		0.020
S		0.015
Cr		0.10
Ni	2.20	2.60
Mo		0.10
V		0.05
Nb		0.05
Cu		0.30

MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO			AWS
	As welded	Min	Max	Min
Rp0.2 (MPa)	460			460
ReL (MPa)				
Rm (MPa)	530	680		550
A4 (%)				19
A5 (%)	20		25	
Charpy V at -60°C (J)	47		75	27

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ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
3.2 x 350	90	150	3.8	113	0.58	45	1.19	68	21.4	1,2,3,4,6,7,8
4.0 x 350	120	180	5.5	96.3	0.51	35	1.49	68	22.5	1,2,3,4,6,7,8
5.0 x 450	180	270	10.4	109.7	0.65	15	2.74	89	23	1,2,3,4
6.0 x 450	230	320	13.4	103	0.68	11	3.62	91	23.4	1,2,3,4

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)