

FILARC 48

General purpose rutile all-positional electrode with particularly satisfying results in the overhead welding of fillet welds, lap joints and sealing runs.

Specifications	
Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 42 0 RC 11
Approvals	ABS : 2 BV : 2 CE : EN 13479 DB : 10.105.06 DNV : 2 LR : 2 UKCA : EN 13479 VdTÜV : 03086

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

Welding Current	AC, DC-(+)
Alloy Type	Carbon Manganese
Coating Type	Rutile-cellulosic covering

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	450 MPa	520 MPa	26 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	0 °C	60 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.07	0.45	0.42

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 350.0 mm	60-110 A	23 V	62 %	44 sec	0.9 kg/h
3.2 x 350.0 mm	90-140 A	24 V	59 %	57 sec	1.1 kg/h
4.0 x 350.0 mm	110-210 A	26 V	59 %	62 sec	1.5 kg/h