FILARC KV3L

Application: All position basic coated electrode with max 0.05% C, for welding creep resisting steels alloyed with 2.25Cr/1Mo, such as 10 CrMo 9 10. The FILARC KV3L is also recommended for welding 0.5Cr/0.5Mo/0.025V steels. The chemical composition of the weld metal guarantees a low sensitivity to solidification cracking, as a result of Mn/Si control. A minimum preheat and interpass temperature of 165-190 °C, is recommended for all material thicknesses.

Specifications	
Classifications	SFA/AWS A5.5 : E8015-B3L EN ISO 3580-A : E CrMo2L B 2 2 H5
Approvals	VdTÜV Seproz : UNA 272581

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

Welding Current	DC+
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	Low alloyed
Coating Type	Basic

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	65-95 A	24 V	57 %	63 sec	0.7 kg/h
3.2 x 350.0 mm	90-130 A	24 V	55 %	70 sec	1.0 kg/h
4.0 x 350.0 mm	125-165 A	24 V	57 %	80 sec	1.3 kg/h