

## Filarc 35S

CTOD-tested, universal basic electrode for welding dynamically loaded structures, particularly in heavy plate, where the high deposition can be used to advantage. Satisfactory CTOD results are obtained in the stress-relieved condition.

| Specifications  |                                                                                |
|-----------------|--------------------------------------------------------------------------------|
| Classifications | SFA/AWS A5.1 : E7018-1<br>EN ISO 2560-A : E 42 4 B 32 H5                       |
| Approvals       | 3Y : ABS<br>10.105.02 : DB<br>3, 3Y H15 : LR<br>00658 : VdTÜV<br>EN 13479 : CE |

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

| Typical Tensile Properties |                |                  |            |
|----------------------------|----------------|------------------|------------|
| Condition                  | Yield Strength | Tensile Strength | Elongation |
| As Welded                  | >420 MPa       | 510-600 MPa      | >26 %      |

| Deposition Data |           |         |                |                 |
|-----------------|-----------|---------|----------------|-----------------|
| Diameter        | Current   | Voltage | Efficiency (%) | Deposition Rate |
| 4 mm            | 110-170 A | 23 V    | 120 %          | 1.6 kg/h        |
| 5 mm            | 160-260 A | 23 V    | 120 %          | 2.6 kg/h        |
| 6 mm            | 240-290 A | 22 V    | 120 %          |                 |
| 2 mm            | 50-80 A   | 26 V    | 120 %          |                 |
| 2.5 mm          | 70-100 A  | 22 V    | 120 %          |                 |
| 2.5 mm          | 70-100 A  | 24 V    | 120 %          |                 |
| 3.2 mm          | 90-140 A  | 23 V    | 120 %          | 1.4 kg/h        |
| 3.2 mm          | 90-150 A  | 23 V    | 120 %          | 1.4 kg/h        |