

Filarc 36D

All-positional basic electrode designed for vertical-up welding of pipes. All diameters have a special double coated coating providing excellent properties for root pass welding.

Specifications	
Classifications	SFA/AWS A5.1 : E7016 EN ISO 2560-A : E 42 4 B 22 H10
Approvals	CE : EN 13479 DNV : 3 YH10 LR : 3Y H10

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

Welding Current	DC+-
Alloy Type	Carbon Manganese
Coating Type	Basic covering

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	470 MPa	540 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	-40 °C	80 J
As Welded	-20 °C	150 J

Deposition Data						
Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	50-100 A	24 V	63 %	79	49 sec	1.0 kg/h
3.2 x 350.0 mm	80-140 A	26 V	60 %	52	57 sec	1.2 kg/h
3.2 x 450.0 mm	80-140 A	26 V	61 %	39	70 sec	1.3 kg/h