

Filarc KV2

Application: FILARC KV2 is a high purity, basic coated, all position electrode for welding creep resisting steels, containing 0.5Mo, such as 15 Mo3 and for tube steels like 15 Ni Cu Mo Nb 5. This type is also frequently applied for welding C-Mn steels where higher tensile weld metal is required. Welding advice: Use short arc. Preheat and interpass temperature 93-107°C.

Specifications	
Classifications	SFA/AWS A5.5 : E7015-A1 EN ISO 3580-A : E Mo B 2 2 H5
Approvals	CE : EN 13479 DB : 10.105.13 VdTUV : 00768 Sepro : 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

Typical Tensile Properties	
Condition	Conditional Statement
AWS	
PWHT	620°C 1h
ISO	
PWHT	620°C 1h

Deposition Data						
Diameter	Current	Voltage	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 350 mm	90-130 A	24 V	0.57	50.0	70 sec	1.0 kg/h
4.0 x 350 mm	125-165 A	24 V	0.58	34.5	80 sec	1.3 kg/h
5.0 x 450 mm	170-220 A	25 V	0.61	16.9	98 sec	2.2 kg/h