

FILARC 27P

This low hydrogen electrode is specially designed for downhill welding circumferential joints in pipes. The low hydrogen weld metal provides high notch toughness and excellent ductility to reduce the risk of cracking. The electrode is used particularly for pipelines, compressor stations, hot tapping and associated work using pipe steels in API 5LX52 to X70 grades in the oil and gas distribution industries, also process piping etc. Productivity is overall 25-30% faster than cellulosic electrodes and 40-50% faster than conventional low hydrogen electrodes for welding vertically up. Welding advice : Keep short arc using beaded or weaved runs. 2.5 mm size can also be welded uphill for increased heat input. DC- is preferred.

Specifications	
Classifications	SFA/AWS A5.5 : E8018-G (nearest) EN ISO 2560-A : E 46 4 B 41 H5
Approvals	ABS : 3Y BV : 3Y H10 CE : EN 13479 DB : 10.105.03 DNV-GL : 3 YH10 LR : 4Y40 H10 VdTÜV : 02591 Sepro : UNA 272581

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

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

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	560 MPa	610 MPa	29 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-40 °C	90 J
As Welded	-50 °C	70 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.08	1.2	0.5

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	80-100 A	25 V	67 %	53 sec	1.0 kg/h
3.2 x 350.0 mm	110-150 A	26 V	68 %	53 sec	1.6 kg/h
4.0 x 350.0 mm	180-220 A	28 V	74 %	50 sec	2.8 kg/h