

FILARC 35

General purpose basic DC+(-) electrode for mild and low alloy steels. Very good running characteristics give high quality welds with good impact values.

Specifications	
Classifications	SFA/AWS A5.1 : E7018 EN ISO 2560-A : E 42 4 B 42 H5
Approvals	ABS : 3Y H10 BV : 3Y H10 CE : EN 13479 UKCA : EN 13479 VdTUV : 02556

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

Welding Current	DC+(-)
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	440 MPa	530 MPa	30 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-40 °C	60 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.05	1.0	0.7

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.0 x 300.0 mm	35-80 A	22 V	63 %	50 sec	0.6 kg/h
2.5 x 350.0 mm	75-105 A	24 V	64 %	58 sec	1.0 kg/h
3.2 x 450.0 mm	95-155 A	26 V	61 %	80 sec	1.5 kg/h
4.0 x 450.0 mm	125-210 A	24 V	67 %	85 sec	2.1 kg/h