

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 EN ISO 2560-A : E 42 4 B 32 H5
Approvals	3Y : ABS 10.105.02 : DB 3, 3Y H15 : LR 00658 : VdTÜV EN 13479 : CE

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

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

Deposition Data				
Diameter	Amps	Volts	Efficiency (Per)	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