

FILARC 76S

CTOD tested, all-position basic AC/DC electrode for offshore fabrication. Alloyed with max 1% nickel. Good CVN toughness down to -60° C. CTOD tested in the AW and SR conditions. Use short arc. Weave slowly when permitted. DC+. Use DC- for root pass.

Specifications	
Classifications	SFA/AWS A5.5 : E7018-G EN ISO 2560-A : E 46 6 Mn1Ni B 32 H5
Approvals	ABS : 3Y H5 BV : 3Y H5 CE : EN 13479 DNV-GL : 3 YH5 LR : 5Y42 H5 Seproz : UNA 272581

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

Welding Current	AC, DC+-
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	Low alloyed (0.9 % Ni)
Coating Type	Basic covering

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	550 MPa	630 MPa	28 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-40 °C	110 J
As Welded	-60 °C	75 J

Typical Weld Metal Analysis %					
C	Mn	Si	Ni	Cr	Mo
0.05	1.58	0.36	0.87	0.04	0.01

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per l max	Deposition rate at 90Per
2.5 x 350.0 mm	55-85 A	24 V	65 %	59 sec	0.7 kg/h
3.0 x 350.0 mm	100-125 A	21 V	63 %	63 sec	1.05 kg/h
3.2 x 350.0 mm	80-140 A	23.8 V	57 %	60 sec	1.12 kg/h
3.5 x 350.0 mm	125-175 A	21.6 V	61 %	63 sec	1.4 kg/h
4.0 x 350.0 mm	120-180 A	22 V	63 %	78 sec	1.51 kg/h
4.0 x 450.0 mm	120-170 A	22.2 V	60.8 %	109 sec	1.4 kg/h
5.0 x 450.0 mm	180-270 A	24.3 V	62 %	106 sec	2.22 kg/h