

FILARC 56S

Basic thin coated AC/DC electrode providing excellent mechanical properties. The electrode ensures fully penetrated root passes even under adverse conditions. Low moisture content of the coating has a high resistance to moisture re-absorption. The electrode is CTOD-tested.

Specifications	
Classifications	SFA/AWS A5.1 : E7016-1 H4 R EN ISO 2560-A : E 42 5 B 1 2 H5
Approvals	ABS : 3YH5 BV : 3YH5 CE : EN 13479 DB : 10.105.15 DNV-GL : 4 YH5 LR : 4Y40 H5 VdTÜV : 03012 RS : 4Y42H5

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

Welding Current	AC, DC+(-)
Diffusible Hydrogen	< 4.0 ml/100g
Alloy Type	Carbon manganese
Coating Type	Basic covering

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	470 MPa	550 MPa	30 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-45 °C	150 J
As Welded	-50 °C	140 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.06	1.3	0.4

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	55-85 A	22 V	58 %	50 sec	0.8 kg/h
3.2 x 350.0 mm	80-140 A	22 V	61 %	53 sec	1.3 kg/h
3.2 x 450.0 mm	80-130 A	22 V	61 %	73 sec	1.2 kg/h
4.0 x 350.0 mm	110-180 A	22 V	64 %	62 sec	1.7 kg/h
4.0 x 450.0 mm	110-170 A	22 V	65 %	83 sec	1.7 kg/h
5.0 x 450.0 mm	180-230 A	22 V	66 %	90 sec	2.4 kg/h