

FILARC Product Data Sheet

FILARC 35S

E 'Manual metal-arc welding'
ESAB Perstorp AB Sweden

Prepared by P-O Oskarsson	Qualified by Tero Tolonen	Approved by J-P Ernoult	Reg no EN006571	Cancelling EN004612	Reg date 2014-10-28	Page 1 (2)
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REASON FOR ISSUE

Approvals and economic data up dated

GENERAL

A basic low hydrogen electrode designed for DC welding.

Min AC OCV: 65

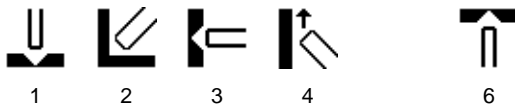
Polarity: AC, DC+

Alloy Type: Carbon manganese

Coating Type: Lime Basic

Diff Hydrogen: <4.0 ml/100g

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.1 E7018-1
EN ISO 2560-A E 42 4 B 32 H5

APPROVALS

ABS 3YH5
CE EN 13479
DB 10.105.02
LR 3YH5
VdTÜV 00658

APPROVALS (SPECIFIC)

Seproz UNA 272581

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.04	0.09
Si	0.20	0.60
Mn	0.90	1.40
P		0.030
S		0.020

MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO		AWS		AWS	
	Min	Max	Min	Max	Min	Max
ReL (MPa)	420		420		380	
Rm (MPa)	500	640	510	600	490	570
A4-A5 (%)					28	
A4 (%)			26			
A5 (%)	20					
at -20°C (J)			100		100	
at -40°C (J)	47		50		50	
at -46°C (J)			27		27	
Comments:	Elongation = A5		Comments: Elongation = A4		Comments: Elongation = A4	

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ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 350	70	100	2.4	120.6	0.59	69.4	0.82	63.5	23.1	1,2,3,4,6
3.2 x 450	90	140	4.73	122	0.74	31	1.35	84	23	1,2,3,4,6
4.0 x 450	110	190	7.2	107.2	0.58	24	1.67	89.6	23.1	1,2,3,4,6
5.0 x 450	160	260	8.7	115.5	0.66	14.2	2.62	96.8	22.9	1,2,3

W = Weight (kg / 100 electrodes) **η** = Efficiency (g weld metal x 100 / g core wire)**N** = Effective value (kg weld metal / kg electrodes)**B** = Changes (number of electrodes / kg weld metal)**H** = Deposit rate at 90% of max current (kg weld metal / hour arc time)**T** = Fusion time at 90% of max current (s / electrode)**U** = Arc voltage (V)