

FILARC Product Data Sheet

FILARC 56R

E 'Manual metal-arc welding'
ESAB AB Sweden

Signed by P-O Oskarsson	Approved by Tony Dray/Christos Skodras	Reg no EN004685	Cancelling EN002572	Reg date 2008-12-29	Page 1 (2)
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REASON FOR ISSUE

Approvals up dated

GENERAL

A basic low hydrogen electrode for enclosed arc welding, particularly for the new higher strength rail steels.

Min AC OCV: 65V

Polarity: DC+

Alloy Type: C, Mn

Coating Type: Basic

Diff Hydrogen: <5.0 ml/100g

WELDING POSITIONS



CHEMICAL COMPOSITION

	All Weld Metal (%)	
	Min	Max
C	0.07	0.11
Si	0.20	0.50
Mn	0.70	1.25
P		0.025
S		0.025
Cr	2.00	2.50

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	ISO	As welded
	Min	
Rp0.2 (MPa)	800	
Rm (MPa)	850	
A4-A5 (%)	15	

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ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U
	Min	Max							
5.0 x 450	280	340	9.2	105.1	0.695	15.7	3.16	72.5	25.7
6.0 x 450	320	380	13.4	105.2	0.684	10.9	3.54	93.3	24.7

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)