

Filarc 48



General purpose rutile all-positional electrode with particularly satisfying results in the overhead welding of fillet welds, lap joints and sealing runs.

Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 42 0 RC 11
Approvals	ABS 2 BV 2 CE EN 13479 DB 10.105.06 DNV 2 GL 2Y LR 2 VdTUV 03086 RS 2

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

Welding Current	AC, DC-(+)
Alloy Type	Carbon Manganese
Coating Type	Rutile-cellulosic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	450 MPa	520 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	0 °C	60 J

Typical Weld Metal Analysis %

C	Mn	Si
0.08	0.60	0.40

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 350.0 mm	60-90 A	25 V	91	49 sec	62 %	0.8 kg/h
3.2 x 350.0 mm	90-140 A	24 V	59	57 sec	59 %	1.1 kg/h
4.0 x 350.0 mm	110-185 A	26 V	40	64 sec	58 %	1.4 kg/h