

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 coating and high resistance to moisture re-absorption. The electrode is CTOD tested.

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 4Y40H5, VdTÜV 03012, RS 4Y42H5, Seproz UNA 272581

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	470 MPa	550 MPa	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	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	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm	55-85 A	22 V	0.58 kg	90.0	50 sec	0.80 kg/h
3.2 x 350 mm	80-140 A	22 V	0.61 kg	52.0	53 sec	1.30 kg/h
3.2 x 450 mm	80-130 A	22 V	0.61 kg	41.0	73 sec	1.20 kg/h
4.0 x 350 mm	110-180 A	22 V	0.64 kg	34.0	62 sec	1.70 kg/h
4.0 x 450 mm	110-170 A	22 V	0.65 kg	26.0	83 sec	1.70 kg/h
5.0 x 450 mm	180-230 A	22 V	0.66 kg	17.0	90 sec	2.40 kg/h