FILARC 118



All position basic AC/DC electrode with 120% recovery for welding high-strength, fine-grained constructional steels (> 690 MPa) with excellent sub-zero toughness down to -50 degrees C and low diffusible hydrogen levels. Use shortest possible arc. Weave slowly when permitted. A slight weave can be used for standing fillet welds. Use DC- for root runs

Specifications	
Classifications	SFA/AWS A5.5 : E11018-M H4R EN ISO 18275-A : E 69 5 Mn2NiMo B 32 H5
Approvals	ABS : E11018-M CE : EN 13479 DNV : 4 Y62H5 LR : 4Y62 H5 UKCA : EN 13479

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

Welding Current	AC, DC+-
Diffusible Hydrogen	< 4.0 ml/100g
Alloy Type	Low alloyed (2.3 % Ni, 0.4 % Mo)
Coating Type	Basic covering
Min AC OCV	65V

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	730 MPa	800 MPa	22 %
ISO			
As Welded	750 MPa	820 MPa	20 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	-50 °C	80 J
ISO		
As Welded	-50 °C	85 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Nb
0.06	1.65	0.42	0.010	0.015	2.27	0.03	0.44	0.015	0.01

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm	65-100 A	26 V	63 %	52 sec	0.96 kg/h
3.2 x 350 mm	95-150 A	23 V	62 %	67 sec	1.35 kg/h
4.0 x 450 mm	115-190 A	23 V	67 %	95 sec	1.79 kg/h
5.0 x 450 mm	190-270 A	25 V	68 %	110 sec	2.46 kg/h