FILARC 98S



All positional low hydrogen electrode for welding of higher strength steels, depositing weld metal with a minimum yield strength of 550 N/mm2 after stress relieving.

Specifications	
Classifications	SFA/AWS A5.5 : E9018-G EN ISO 18275-A : E 55 6 Mn1NiMo B T 32 H5
Approvals	ABS : E9018-G CE : EN 13479 UKCA : EN 13479

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

Welding Current	AC, DC+-
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	Low alloyed (0.9 % Ni, 0.3 % Mo)
Coating Type	Basic covering
Min AC OCV	65V

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
PWHT 1 hour(s) 580 °C	650 MPa	710 MPa	21 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
PWHT 1 hour(s) 580 °C	-50 °C	80 J
PWHT 1 hour(s) 580 °C	-60 °C	60 J

Typical Weld Metal Analysis %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**
0.06	1.85	0.35	0.89	0.05	0.32

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 350 mm	55-85 A	24.4 V	60 %	60 sec	0.72 kg/h
3.2 x 350 mm	80-140 A	23.3 V	55 %	68 sec	0.94 kg/h
4.0 x 450 mm	120-180 A	24.0 V	60 %	103 sec	1.43 kg/h