

Filarc 88S



A basic coated low hydrogen electrode alloyed with max 1% Ni for the positional welding of higher tensile steels, BS4360-55F steel and similar grades. Good CVN toughness down to -60°C ; CTOD tested in the AW and SR conditions. Many approved welding procedures are available. Use short arc. Weave slowly when permitted. Use DC- for root passes.

Classifications	SFA/AWS A5.5 : E8016-G EN ISO 2560-A : E 50 6 Mn1Ni B 12 H5
Approvals	ABS E8016-G CE EN 13479 DB 10.105.16 DNV-GL 5Y46 H5 LR 5Y46 H5 NAKS/HAKC 2.5-4.0 mm RS 5Y46 H5 VdTUV 06107 Sepron UNA 272581

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)
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	560 MPa	640 MPa	27 %

Typical Charpy V-Notch Properties

Condition
ISO
As Welded
As Welded

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.06	1.77	0.27	0.9	0.03	0.01

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	55-85 A	25.7 V	74.18	51.47 sec	61.11 %	0.96 kg/h
3.2 x 350.0 mm	80-140 A	21.4 V	54.5	69 sec	59 %	0.96 kg/h
4.0 x 450.0 mm	110-170 A	21.5 V	26.8	106 sec	62 %	1.27 kg/h
5.0 x 450.0 mm	180-230 A	22.6 V	16.9	109 sec	63 %	1.95 kg/h