

FILARC Product Data Sheet

FILARC C23

E 'Manual metal-arc welding'
ESAB AB Sweden

Signed by P-O Oskarsson	Approved by Tony Dray/Christos Skodras	Reg no EN004690	Cancelling EN003358	Reg date 2008-12-31	Page 1 (2)
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REASON FOR ISSUE

ABS approval up dated

GENERAL

Rutile iron-powder electrode with 160 % recovery, depositing very smooth standing fillet welds at high deposition rates.

Min AC OCV: 50 V

Polarity: AC, DC-

Alloy Type: Carbon steels

Coating Type: Rutile

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.1 E7024
EN ISO 2560-A E 42 0 RR 53

APPROVALS

ABS 2Y
BV 2, 2Y
CE EN 13479
DNV 2
GL 2Y
LR 2, 2Y
VdTÜV 00652

APPROVALS (SPECIFIC)

RS 2Y

CHEMICAL COMPOSITION

	All Weld Metal (%)	
	Min	Max
C	0.06	0.11
Si	0.30	0.70
Mn	0.50	1.00
P		0.030
S		0.030

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MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal			
	ISO		AWS	
	As welded		As welded	
	Min	Max	Min	Max
Rp0.2 (MPa)			430	
ReL (MPa)	420			
Rm (MPa)	500	640	510	570
A4 (%)			24	
A5 (%)	20			
Charpy V at 0°C (J)	47		54	
Charpy V at -20°C (J)			28	

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U
Ø x Length	Min	Max							
3.2 x 450	130	160	6.97	160	0.6	24	1.9	78	27
4.0 x 450	170	210	10.0	154	0.6	17	3.1	69	32
5.0 x 450	240	340	15.9	164	0.6	10	4.2	77	32

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)