FILARC PZ6148

A basic cored wire suitable for the welding steels with a minimum yield strength of 690 Mpa for for use with M21 shielding gas. Diameters less than 1.4mm are all-positional.

Specifications	
Classifications	EN 12535 : T 69 5 Mn2NiCrMo B M21 2 H5 SFA/AWS A5.29 : E111T5-K4M H4

Welding Current	DC-
Alloy Type	Low alloy (2%Ni, 0.5% Mo, 0.5% Cr)

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
M21 shielding gas			
As Welded	817 MPa	879 MPa	18.5 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
M21 shielding gas		
As Welded	-50 °C	69 J

Typical Weld Metal Analysis %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**
M21 Shielding gas					
0.075	1.67	0.47	2.18	0.48	0.48

Deposition Data				
Diameter	**Amps**	**Volts**	**Wire Feed Speed**	**Deposition Rate**
1.2 mm	150-350 A	20-35 V	5.8-22.0 m/min	2.1-7.9 kg/h