FILARC PZ6138

An all-positional rutile cored wire for use with M21 providing very good toughness down to -60 °C.

Specifications	
Classifications	EN ISO 17632-B : T 55 5 T1 M A N2 U H5 SFA/AWS A5.29 : E81T1-Ni1M JH4 EN ISO 17632-A : T 50 6 1Ni P M21 1 H5
Approvals	ABS : 3SA 3YSA H5 BV : S3YM H5 CE : EN 13479 DB : 42.105.08 DNV-GL : V Y46MS(H5) LR : 5Y40M H5 LR : 5Y40S H5 LR : 5Y42S H5 UKCA : EN 13479 VdTÜV : 04903 PRS : 3YS H5 (approved to -60°C) PRS : 5Y40S H5

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

Welding Current	DC+
Alloy Type	Low alloy
Shielding Gas	M21 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
M21			
As Welded	577 MPa	616 MPa	29 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
M21		
As Welded	-20 °C	145 J
As Welded	-40 °C	130 J
As Welded	-60 °C	114 J

Typical Weld Metal Analysis %				
C	**Mn**	**Si**	**Ni**	**Cu**
M21				
0.04	1.1	0.33	0.93	0.021

Deposition Data				
Diameter	**Current**	**Voltage**	**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
1.4 mm	150-350 A	26-34 V	3.2-11.1 m/min	1.8-6.3 kg/h
1.6 mm	150-450 A	24-36 V	2.6-11.9 m/min	1.8-8.1 kg/h