

FILARC PZ6111

A downhand rutile cored wire for use with C1 or M21 shielding gas.

Specifications	
Classifications	SFA/AWS A5.29 : E70T1-G EN ISO 17632-A : T 42 2 1Ni R C1 3 H10 EN ISO 17632-A : T 46 2 1Ni R M21 3 H10
Approvals	ABS : 3SA, 3YSA H10 BV : S3M, S3YM HH CE : EN 13479 DB : 42.105.06 DNV : III YMS (H10) LR : 3YM H10 LR : 3YS H10 PRS : 3YS H10 UKCA : EN 13479 VdTÜV : 03013

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

Welding Current	DC+
Alloy Type	Low alloy (<1% Ni)

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	495 MPa	576 MPa	22 %
C1 shielding gas			
As Welded	465 MPa	530 MPa	22 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
M21 shielding gas		
As Welded	-20 °C	114 J
C1 shielding gas		
As Welded	-20 °C	89 J

Typical Weld Metal Analysis %			
C	Mn	Si	Ni
Shielding Gas M21			
0.062	1.07	0.53	0.70

Deposition Data				
Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	150-350 A	27-38 V	5.8-20.7 m/min	2.1-7.5 kg/h
1.4 mm	150-350 A	26-36 V	3.4-12.0 m/min	1.8-6.3 kg/h
1.6 mm	150-450 A	24-40 V	2.8-12.4 m/min	1.6-8.1 kg/h