

FILARC PZ6138S SR

An all-positional rutile cored wire for use with carbon dioxide shielding gas, providing very good toughness down to -60°C after stress relief.

Specifications

Classifications	SFA/AWS A5.29 : E81T1-Ni1C J EN ISO 17632-A : T 46 6 1Ni P C1 1 H5
Approvals	ABS : 5Y42M H5 ABS : 5Y46M H5 BV : 5Y42 H5 (C1) BV : 5Y46 H5 (C1) CE : EN 13479 DNV-GL : V Y42MS (H5) (C1) DNV-GL : V Y46MS (H5) (C1) UKCA : EN 13479

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

Welding Current	DC+
Alloy Type	Low alloy
Shielding Gas	C1 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
C1 Shielding gas			
Stress Relieved 2 hour(s) 600 °C	480 MPa	560 MPa	25 %
As Welded	498 MPa	579 MPa	28 %
C1 shielding gas			
Stress Relieved 2 hour(s) 600 °C	480 MPa	560 MPa	25 %
As Welded	498 MPa	579 MPa	28 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
C1 Shielding gas		
As Welded	-60 °C	90 J
Stress Relieved	-60 °C	83 J
C1 shielding gas		
As Welded	-60 °C	90 J
Stress Relieved	-60 °C	83 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
C1 Shielding gas			
0.05	1.3	0.30	0.90

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	175-350 A	25-38 V	5.6-12.8 m/min	2.8-8.1 kg/h