

FILARC PZ6115

An all-positional rutile cored wire for use with mixed gas providing very good toughness down to -50 °C.

Specifications

Classifications	EN ISO 17632-A : T 50 5 2Ni P M21 2 H5
Approvals	BV : SA5Y50M H5 (M21) DNV-GL : V Y50MS(H5) NAKS/HAKC : 1.2 mm RS : 5Y50MSH5 (M21)

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 shielding gas			
As Welded	557 MPa	662 MPa	21 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-50 °C	93 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
M21 shielding gas			
0.054	1.06	0.39	2.36

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	150-350 A	27-35 V	5.6-19.8 m/min	2.1-7.5 kg/h