

FILARC PZ6102

A metal cored wire designed for welding with Ar/CO₂ shielding gas mixture. Diameters less than 1.4mm are all-positional except vertical down.

Specifications

Classifications	SFA/AWS A5.18 : E70C-6M H4 EN ISO 17632-A : T 46 4 M M21 2 H5 EN ISO 17632-A : T 46 4 M M24 2 H5
Approvals	ABS : 3SA, 3YSA H5 BV : S3M, S3YM H5 CE : EN 13479 DB : 42.105.09 DB : 42.105.09 DNV : IV YMS(H5) DNV-GL : IV YMS (H5) LR : 4Y46M H5 LR : 4Y46S H5 UKCA : EN 13479 VdTÜV : 04901

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

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	485 MPa	570 MPa	28.9 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-40 °C	75 J

Typical Weld Metal Analysis %

C	Mn	Si
M21 shielding gas		
0.075	1.55	0.65

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	130-350 A	16-34 V	4.6-18.5 m/min	2.0-8.0 kg/h
1.4 mm	150-380 A	18-34 V	2.5-9.0 m/min	1.8-7.0 kg/h
1.6 mm	150-450 A	17-36 V	2.0-9.3 m/min	1.7-7.8 kg/h