

FILARC PZ6138SR

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

Specifications

Classifications	SFA/AWS A5.29 : E81T1-Ni1M J H4 EN ISO 17632-A : T 46 6 1Ni P M21 1 H5
Approvals	ABS : 4YSA H5 DNV : V Y42MS H5 LR : 5Y42S H5 LR : 5Y42srS H5 NAKS/HAKC : 1.2MM

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			
Stress Relieved 2 hour(s) 600 °C	505 MPa	585 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21		
Stress Relieved	-60 °C	84 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
0.048	1.24	0.37	0.84

Deposition Data

Diameter	Current	Voltage	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