# FILARC PZ6111

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

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