

## FILARC PZ6113S

A multi-purpose all-positional rutile cored wire for use with C1 shielding gas. Diameters less than 1.4mm are all-positional except vertical down.

### Specifications

|                        |                                                                         |
|------------------------|-------------------------------------------------------------------------|
| <b>Classifications</b> | SFA/AWS A5.20 : E71T-9C H4<br>EN ISO 17632-A : T 46 3 P C1 2 H5         |
| <b>Approvals</b>       | CE : EN 13479<br>DNV : III YMS(H10)<br>UKCA : EN 13479<br>VdTÜV : 07085 |

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

|                        |                   |
|------------------------|-------------------|
| <b>Welding Current</b> | DC+               |
| <b>Alloy Type</b>      | CMn               |
| <b>Shielding Gas</b>   | C1 (EN ISO 14175) |

### Typical Tensile Properties

| Condition               | Yield Strength | Tensile Strength | Elongation |
|-------------------------|----------------|------------------|------------|
| <b>C1 shielding gas</b> |                |                  |            |
| As Welded               | 560 MPa        | 628 MPa          | 23.3 %     |

### Typical Charpy V-Notch Properties

| Condition               | Testing Temperature | Impact Value |
|-------------------------|---------------------|--------------|
| <b>C1 shielding gas</b> |                     |              |
| As Welded               | -20 °C              | 125 J        |
| As Welded               | -30 °C              | 109 J        |
| As Welded               | 0 °C                | 140 J        |

### Typical Weld Metal Analysis %

| C                       | Mn   | Si   |
|-------------------------|------|------|
| <b>C1 shielding gas</b> |      |      |
| 0.065                   | 1.27 | 0.43 |

### Deposition Data

| Diameter | Current   | Voltage | 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    |