FILARC PZ6222

An all-positional rutile cored wire for 0.5% Mo creep resisting steels used with M21 shielding gas.

Specifications	
Classifications	SFA/AWS A5.29 : E81T1-A1M H4 EN ISO 17634-A : T MoL P M 2 H5
Approvals	VdTÜV : 07071

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

Welding Current	DC+
Alloy Type	Low alloy (0.5% Mo)
Shielding Gas	M21 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
M21 shielding gas			
PWHT 1 hour(s) 610 °C	533 MPa	592 MPa	24.1 %
As Welded	573 MPa	635 MPa	24 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
M21 shielding gas		
As Welded	20 °C	75 J
PWHT	20 °C	69 J

Typical Weld Metal Analysis %			
C	**Mn**	**Si**	**Mo**
M21 shielding gas			
0.036	0.76	0.41	0.47

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