

FILARC PZ6114

An all-positional rutile cored wire with excellent toughness down to low, sub-zero temperatures, for use with M21 shielding gas

Specifications	
Classifications	EN ISO 17632-B : T 55 5 T12-1 M21 A-U H5 SFA/AWS A5.20 : E71T-1MJ H4 EN ISO 17632-A : T 46 5 P M21 1 H5
Approvals	ABS : 4Y400SA H5 BV : S4Y40 H5 CE : EN 13479 CRS : 4YH5S DB : 42.105.16 DNV : IV Y40MS(H5) LR : 3YM H5 LR : 3YS H5 PRS : 3YS H5 UKCA : EN 13479 VdTÜV : 07669

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

Welding Current	DC+
Alloy Type	CMn

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	529 MPa	586 MPa	25.5 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-50 °C	124 J
As Welded	-40 °C	130 J

Typical Weld Metal Analysis %			
C	Mn	Si	Ni
M21 shielding gas			
0.056	1.25	0.41	0.41

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	100-300 A	25-35 V	4.5-23.0 m/min	1.2-6.2 kg/h
1.2 mm	150-350 A	27-35 V	5.6-19.8 m/min	2.1-7.5 kg/h