FILARC PZ6114S

An all-positional rutile cored wire with good toughness down to -40 °C for use with C1 shielding gas.

Specifications	
Classifications	SFA/AWS A5.20 : E71T-1CJ H4 EN ISO 17632-A : T 46 4 P C1 1 H5
Approvals	BV : S4YM H5 CE : EN 13479 DNV-GL : IV Y40MS(H5) LR : 3YS H5, 3YM H5 PRS : 3YS H5 UKCA : EN 13479

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**
C1 shielding gas			
As Welded	539 MPa	605 MPa	23.9 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
C1 shielding gas		
As Welded	-40 °C	105 J

Typical Weld Metal Analysis %			
C	**Mn**	**Si**	**Ni**
C1 shielding gas			
0.06	1.39	0.43	0.40

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