

Filarc PZ6103

A general purpose metal cored wire for use with M21 shielding gas. Diameters less than 1.4mm are all-positional except vertical down.

Specifications

Classifications	SFA/AWS A5.18 : E70C-GM H4 EN ISO 17632-A : T 42 2 M M21 2 H5
Approvals	CE : EN 13479 DB : 42.105.05 LR : 3YS H5 (M21) VdTÜV : 04461

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

Welding Current	DC+-
Alloy Type	CMn
Shielding Gas	M21 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	463 MPa	568 MPa	28.7 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-20 °C	109 J

Typical Weld Metal Analysis %

C	Mn	Si
M21 shielding gas		
0.066	1.36	0.85

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	150-350 A	21-35 V	5.0-21.3 m/min	2.1-9.0 kg/h
1.4 mm	150-350 A	18-33 V	3.5-12.1 m/min	2.1-7.2 kg/h
1.6 mm	150-450 A	17-34 V	2.7-12.3 m/min	2.1-9.6 kg/h