

FILARC PZ6148

A basic cored wire suitable for the welding steels with a minimum yield strength of 690 Mpa for use with M21 shielding gas. Diameters less than 1.4mm are all-positional.

Specifications

Classifications	EN 12535 : T 69 5 Mn2NiCrMo B M21 2 H5 SFA/AWS A5.29 : E111T5-K4M H4
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Welding Current	DC-
Alloy Type	Low alloy (2%Ni, 0.5% Mo, 0.5% Cr)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	817 MPa	879 MPa	18.5 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
M21 shielding gas		
As Welded	-50 °C	69 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
M21 Shielding gas					
0.075	1.67	0.47	2.18	0.48	0.48

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	150-350 A	20-35 V	5.8-22.0 m/min	2.1-7.9 kg/h