

## FILARC PZ6104

A 1% Ni metal cored wire which gives good toughness down to -50 degrees C using M21 shielding gas. All positional except vertical down.

### Specifications

|                        |                                                                                                                                                                                           |
|------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Classifications</b> | SFA/AWS A5.28 : E70C-GM H4<br>EN ISO 17632-A : T 42 5 Z M M21 2 H5                                                                                                                        |
| <b>Approvals</b>       | ABS : 3SA, 3YSA H5<br>BV : 3YMH5 (M21)<br>CE : EN 13479<br>DB : 42.105.11<br>DNV : IV YMS(H5) (M21)<br>DNV : IV YMS(H5)<br>LR : 3YM H5<br>LR : 3YS H5<br>UKCA : EN 13479<br>VdTÜV : 05477 |

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

|                        |                  |
|------------------------|------------------|
| <b>Welding Current</b> | DC+-             |
| <b>Alloy Type</b>      | Low alloy (1%Ni) |

### Typical Tensile Properties

| Condition                | Yield Strength | Tensile Strength | Elongation |
|--------------------------|----------------|------------------|------------|
| <b>M21 shielding gas</b> |                |                  |            |
| As Welded                | 459 MPa        | 553 MPa          | 28 %       |

### Typical Charpy V-Notch Properties

| Condition                | Testing Temperature | Impact Value |
|--------------------------|---------------------|--------------|
| <b>M21 shielding gas</b> |                     |              |
| As Welded                | -40 °C              | 133 J        |
| As Welded                | -50 °C              | 107 J        |

### Typical Weld Metal Analysis %

| C                        | Mn   | Si   | Ni   |
|--------------------------|------|------|------|
| <b>M21 shielding gas</b> |      |      |      |
| 0.061                    | 1.40 | 0.47 | 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    |