

FILARC PZ6125

A basic cored wire which gives good toughness down to -60 °C for use with M21 shielding gas. Diameters less than 1.4mm are all-positional.

Specifications

Classifications	SFA/AWS A5.29 : E71T5-K6M H4 EN ISO 17632-A : T 42 6 1Ni B M21 1 H5
Approvals	ABS : 3SA, 3YSA H5 BV : S4M, S5YM H5 (M21) CE : EN 13479 DB : 42.105.12 DNV : V Y40MS(H5) LR : 5Y40S H5 UKCA : EN 13479 VdTÜV : 05648

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

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

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	445 MPa	556 MPa	28.4 %
Stress Relieved 2 hour(s) 600 °C	410 MPa	510 MPa	28 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
M21 shielding gas		
Stress Relieved	-40 °C	100 J
As Welded	-60 °C	109 J
Stress Relieved	-60 °C	60 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
M21 shielding gas			
0.084	1.24	0.45	0.85

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.0 mm	100-250 A	16-31 V	5.6-18.6 m/min	1.4-4.7 kg/h
1.2 mm	150-350 A	20-35 V	5.8-22.0 m/min	2.1-7.9 kg/h
1.6 mm	150-450 A	18-36 V	2.8-12.0 m/min	1.8-7.9 kg/h