

FILARC PZ6176

A metal cored wire developed for fabrication and repair of Pelton and Francis wheels and other water turbine components in 16%Cr 5%Ni alloyed soft martensitic steels used with M13 or M14 shielding gas.

Specifications

Classifications	EN 14700 : T Fe7
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Welding Current	DC+
Shielding Gas	M12, M13 (EN439)

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	150-350 A	18-34 V	5.3-16.4 m/min	2.2-7.0 kg/h