

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

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

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

Welding Current	DC+-
Alloy Type	Low alloy (1%Ni)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	459 MPa	553 MPa	28 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
M21 shielding gas		
As Welded	-50 °C	107 J
As Welded	-40 °C	133 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
M21 shielding gas			
0.061	1.40	0.47	0.85

Deposition Data

Diameter	Amps	Volts	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