

FILARC PZ6113S

A multi-purpose all-positional rutile cored wire for use with C1 shielding gas. Diameters less than 1.4mm are all-positional except vertical down.

Specifications

Classifications	SFA/AWS A5.20 : E71T-9C H4 EN ISO 17632-A : T 46 3 P C1 2 H5
Approvals	CE : EN 13479 DNV : III YMS(H10) UKCA : EN 13479 VdTÜV : 07085

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

Welding Current	DC+
Alloy Type	CMn
Shielding Gas	C1 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
C1 shielding gas			
As Welded	560 MPa	628 MPa	23.3 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
C1 shielding gas		
As Welded	-30 °C	109 J
As Welded	-20 °C	125 J
As Welded	0 °C	140 J

Typical Weld Metal Analysis %

C	Mn	Si
C1 shielding gas		
0.065	1.27	0.43

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	150-350 A	27-38 V	5.8-20.7 m/min	2.1-7.5 kg/h