

FILARC PZ6112

An all positional rutile cored wire for weathering steels, used with C1 or M21 shielding gas.

Specifications	
Classifications	SFA/AWS A5.29 : E71T1-G H4 SFA/AWS A5.29 : E81T1-GM H8 EN ISO 17632-A : T 42 2 Z P C1 1 H5 EN ISO 17632-A : T 46 2 Z P M21 1 H5
Approvals	CE : EN 13479 DB : 42.105.13 UKCA : EN 13479 VdTÜV : 06767

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

Welding Current	DC+
Alloy Type	Low alloy

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	541 MPa	620 MPa	24.6 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-20 °C	66 J

Typical Weld Metal Analysis %				
C	Mn	Si	Ni	Cu
0.065	1.07	0.66	0.66	0.42

Deposition Data				
Diameter	Current	Voltage	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