

FILARC PZ6138 FCAW

Type Rutile

E81T1-Ni1MJ H4

Description

Well established in the offshore sector, PZ6138 alloyed with 0.9% Ni produces reliable Charpy impact properties down to -60°C and CTOD performance to -10°C. The wire exhibits a smooth stable arc with virtually no spatter.

Welding current

DC+



Classifications

SFA/AWS A5.29 E81T1-Ni1MJ H4
EN 758 T 46 5 1 Ni P M 1 H5

Typical all weld metal composition, %

C	Si	Mn	Ni
0.07	0.4	1.3	0.9

Typical mech. properties all weld metal

Yield stress, MPa 520
Tensile strength, MPa 610
Elongation, % 22

Charpy V

Test temps, °C Impact values, J
-60 80

Approvals

ABS	3SA 3YSA	Ar/20%CO ₂
BV	S3 3YMHH	Ar/20%CO ₂
CL	925	Ar/20%CO ₂
DNV	VY42MSH5	Ar/20%CO ₂
DS	T 46 5 1NI P M 1 H10	Ar/20%CO ₂
GL	6YH10S	Ar/20%CO ₂
LR	3S 5Y42S	Ar/20%CO ₂
RS	5Y42MSHH	Ar/20%CO ₂
PRS	3YH10S	Ar/20%CO ₂

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	110-300	21-32