

# FILARC PZ6113S

FCAW

Type Rutile

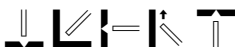
E71T-9 H4

## Description

Firmly established as the leading CO<sub>2</sub>, all-positional, rutile cored wire, PZ6113S has a high degree of welder appeal. For example, the 1.2 mm diameter can weld in several positions at a single current/voltage setting, which explains why it is highly regarded in the shipbuilding segment.

## Welding current

DC+



## Classifications

SFA/AWS A5.20 E71T-9 H4  
EN 758 T 46 3 P C 2 H5

## Typical all weld metal composition, %

C	Si	Mn	Ni
0.07	0.45	1.3	0.4

## Typical mech. properties all weld metal

Yield stress, MPa 560  
Tensile strength, MPa 628  
Elongation, % 24

## Charpy V

Test temps, °C Impact values, J  
-30 109

## Approvals

ABS	3SA 3YSA	CO <sub>2</sub>
BV	SA3 3YMHH	CO <sub>2</sub>
DNV	III YMS (H10)	CO <sub>2</sub>
GL	4Y42H10S	CO <sub>2</sub>
LR	3S 3YS	CO <sub>2</sub>
PRS	3YH10S	CO <sub>2</sub>
RINA	SG 52 3	CO <sub>2</sub>
RS	3YHHS	CO <sub>2</sub>
UDT	EN 758	CO <sub>2</sub>
VdTÜV	07085	CO <sub>2</sub>

## Welding parameters

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