

FILARC PZ6111HS

FCAW

Type Rutile

E70T-1 (nearest)

Description

A high filling ratio, downhand, rutile cored wire that produces weld deposits at rates of up to 15 kg/h with conventional equipment. The finished weld is free from spatter and the self-releasing slag adds to the quality of the finished weld deposit.

Shielding gas Ar+15-25% CO₂ and CO₂.

Welding current

DC+



Classifications

EN 758 T 46 2 1Ni R M 3 H10,
T 42 2 1Ni R C 3 H10

Typical all weld metal composition, %

C	Si	Mn	Ni
0.06	0.45	0.9	0.75

Typical mech. properties all weld metal

Yield stress, MPa 500
Tensile strength, MPa 560
Elongation, % 26

Charpy V

Test temps, °C Impact values, J
-20 97

Approvals

ABS	3SA,3YSA H10	Ar/20%CO ₂ & CO ₂
BV	SA3 YMHH	Ar/20%CO ₂ & CO ₂
DB	42.105.18	Ar/20%CO ₂ & CO ₂
DNV	III Y40MS H10	Ar/20%CO ₂ & CO ₂
DS	T 46 2 1Ni R M 3 H10	Ar/20%CO ₂
DS	T 42 2 1Ni R C 3 H10	CO ₂
GL	3YH10S	Ar/20%CO ₂ & CO ₂
LR	3S 3YS H10	Ar/20%CO ₂ & CO ₂
VdTÜV	07668	Ar/20%CO ₂ & CO ₂

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.6	250-450	26-38