

FILARC PZ6111

FCAW

Type

E70T-1 H8 (nearest) E70T-1M H8 (nearest)

Description

A downhand rutile wire for use with Ar/CO₂ or CO₂ shielding gas in the flat and horizontal/vertical positions. The slag is often self lifting leaving a clean weld bead surface.

Welding current

DC+



Classifications

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

Typical all weld metal composition, %

C	Si	Mn	Ni
0.055	0.45	0.9	0.75

Typical mech. properties all weld metal

Yield stress, MPa	495
Tensile strength, MPa	576
Elongation, %	26

Charpy V

Test temps, °C	Impact values, J
-20	114

Approvals

ABS	3SA, 3YSA	Ar/20%CO ₂ & CO ₂
BV	SA3 3YMHH	Ar/20%CO ₂ & CO ₂
CL	0751	Ar/20%CO ₂
CRS	3YH10S	Ar/20%CO ₂ & CO ₂
DB	42.105.06	Ar/20%CO ₂ & CO ₂
DNV	III YMS (H10)	Ar/20%CO ₂ & CO ₂
DS	T 42 2 1Ni R C 3 H10	CO ₂
DS	T 46 2 1Ni R M 3 H10	Ar/20%CO ₂
GL	3YH10S	Ar/20%CO ₂ & CO ₂
LR	3S 3YS	Ar/20%CO ₂ & CO ₂
PRS	3YH10S	Ar/20%CO ₂ & CO ₂
VdTUV	03013	Ar/20%CO ₂ & CO ₂

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	150-350	27-38
1.4	150-350	26-36
1.6	150-450	24-40