

Filarc PZ6111

A downhand rutile cored wire for use with C1 or M21 shielding gas.

Classifications Weld Metal	SFA/AWS A5.29 : E70T1-G EN ISO 17632-A : T 42 2 1Ni R C1 3 H10 EN ISO 17632-A : T 46 2 1Ni R M21 3 H10
Approvals	ABS 3SA 3YSA H10 BV S3M S3YM HH CE EN 13479 CRS 3Y H10S DB 42.105.06 DNV III YMS (H10) GL 3Y H10S LR 3YS H10 PRS 3YS H10 VdTUV 03013

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

Welding Current	DC+
Alloy Type	Low alloy (<1% Ni)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 shielding gas			
As Welded	465 MPa	530 MPa	28 %
M21 shielding gas			
As Welded	495 MPa	576 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 shielding gas		
As Welded	-20 °C	89 J
M21 shielding gas		
As Welded	-20 °C	114 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
0.062	1.07	0.53	0.70

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
1.4 mm	150-350 A	26-36 V	3.4-12.0 m/min	1.8-6.3 kg/h
1.6 mm	150-450 A	24-40 V	2.8-12.4 m/min	1.6-8.1 kg/h