

## Filarc PZ6138S SR

An all-positional rutile cored wire for use with carbon dioxide shielding gas, providing very good toughness down to -60°C after stress relief.

<b>Classifications Weld Metal</b>	SFA/AWS A5.29 : E81T1-Ni1C J EN ISO 17632-A : T 46 6 1Ni P C1 1 H5
<b>Approvals</b>	ABS 5Y42M H5 ABS 5Y46M H5 BV 5Y42 H5 (C1) BV 5Y46 H5 (C1) CE EN 13479 DNV-GL V Y42MS (H5) (C1) DNV-GL V Y46MS (H5) (C1)

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

<b>Welding Current</b>	DC+
<b>Alloy Type</b>	Low Alloy
<b>Shielding Gas</b>	C1 (EN ISO 14175)

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>C1 Shielding gas</b>			
Stress Relieved 2hr 600°C	480 MPa	560 MPa	25 %
As Welded	498 MPa	579 MPa	28 %
<b>C1 shielding gas</b>			
Stress Relieved 2hr 600°C	480 MPa	560 MPa	25 %
As Welded	498 MPa	579 MPa	28 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>C1 shielding gas</b>		
As Welded	-60 °C	90 J
Stress Relieved 2hr 600°C	-60 °C	83 J

### Typical Weld Metal Analysis %

C	Mn	Si	Ni
0.05	1.3	0.30	0.90

### Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	175-350 A	25-38 V	5.6-12.8 m/min	2.8-8.1 kg/h