FILARC PZ6116S

An all-positional rutile cored wire with good toughness down to -60 °C for use with carbon dioxide shielding gas.

Specifications	
Classifications	SFA/AWS A5.29 : E81T1-K2 C JH4 EN ISO 17632-A : T 46 6 1.5Ni P C1 1 H5
Approvals	ABS : 3SA H5, 3YSA H5 ABS : 4YQ420SA H5 BV : S5Y46H5 BV : SA5Y46H5 CE : EN 13479 DNV-GL : V Y46MS(H5) LR : 5Y40M H5 LR : 5Y40S H5 PRS : 3YS H5 RINA : 4YS RINA : 4Y S UKCA : EN 13479

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

Welding Current	DC+
Alloy Type	Low Alloy
Shielding Gas	C1 (EN ISO 14175)

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	553 MPa	624 MPa	24 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
As Welded	-60 °C	69 J

Typical Weld Metal Analysis %			
C	**Mn**	**Si**	**Ni**
0.054	1.38	0.43	1.42

Deposition Data				
Diameter	**Amps**	**Volts**	**Wire Feed Speed**	**Deposition Rate**
1.2 mm	150-350 A	23-35 V	5.6-19.8 m/min	2.1-7.5 kg/h
1.6 mm	150-450 A	24-36 V	2.8-12.4 m/min	1.8-8.1 kg/h