

## Filarc PZ6113

A multi-purpose all positional rutile cored wire for use with C1 or M21 shielding gas.

<b>Classifications</b>	SFA/AWS A5.20 : E71T-1C H4 SFA/AWS A5.20 : E71T-1M H8 EN ISO 17632-A : T 42 3 P C1 1 H5 EN ISO 17632-A : T 46 4 P M21 1 H5 EN ISO 17632-A : T 46 4 P M24 1 H5
<b>Approvals</b>	ABS : 4YSA H10 (M21), 3YSA H5 (C1) BV : SA3M, SA3YM H5 (C1) BV : SA4YM H10 (M21) CE : EN 13479 CRS : 4YS H10(M21), 3YS H5(C1) DB : 42.105.07 DNV-GL : IV YMS H10 (M21), III YMS (H5) (C1) LR : 3Y(C1) LR : 4Y(M21) NAKS/HAKC : 1.2MM PRS : 4YS H10 (M21), 3YS H5 (C1) RINA : 4YS H10 (M21), 2YS H5 (C1) RS : 3YMSH10 (M21), 3YMSH5 (C1) VdTÜV : 04902

<b>Welding Current</b>	DC+
<b>Alloy Type</b>	CMn

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>M21 Shielding gas</b>			
As Welded	535 MPa	601 MPa	25 %
<b>C1 Shielding gas</b>			
As Welded	495 MPa	585 MPa	25 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>M21 Shielding gas</b>		
As Welded	-40 °C	70 J
<b>C1 Shielding gas</b>		
As Welded	-30 °C	65 J

### Typical Weld Metal Analysis %

C	Mn	Si
<b>C1 shielding gas</b>		
0.06	1.20	0.40

### Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	100-300 A	22-35 V	4.5-23.0 m/min	1.2-6.2 kg/h
1.2 mm	150-350 A	23-35 V	5.8-20.7 m/min	2.1-7.5 kg/h
1.4 mm	150-350 A	22-34 V	3.3-11.6 m/min	1.8-6.3 kg/h
1.6 mm	150-450 A	22-36 V	2.8-12.4 m/min	1.8-8.1 kg/h