

Filarc PZ6138

An all-positional rutile cored wire for use with M21 providing very good toughness down to -60 °C.

Classifications	EN ISO 17632-B : T 55 5 T1 M A N2 U H5 SFA/AWS A5.29 : E81T1-Ni1M JH4 EN ISO 17632-A : T 50 6 1Ni P M21 1 H5
Approvals	ABS : 3YSA H5 BV : S3YM H5 CE : EN 13479 DB : 42.105.08 DNV-GL : V Y46MS(H5) LR : 5Y40S, H5 NAKS/HAKC : 1.2 mm PRS : 5Y40S H5, 3YS H5 RS : 5Y42MSH5 (PV) VdTÜV : 04903 RS : 5Y46MSH5 (PN)

Welding Current	DC+
Alloy Type	Low alloy

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 Shielding gas			
As Welded	577 MPa	616 MPa	29 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 Shielding gas		
As Welded	-40 °C	130 J
As Welded	-20 °C	145 J
As Welded	-60 °C	114 J
M21 shielding gas		
As Welded	-40 °C	130 J
As Welded	-20 °C	145 J
As Welded	-60 °C	114 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cu
M21 Shielding gas				
0.04	1.1	0.33	0.93	0.021

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	150-350 A	20-35 V	5.8-22.0 m/min	2.1-7.9 kg/h
1.4 mm	150-350 A	26-34 V	3.2-11.1 m/min	1.8-6.3 kg/h
1.6 mm	150-450 A	24-36 V	2.6-11.9 m/min	1.8-8.1 kg/h