

Filarc PZ6113

Multi-purpose, all-positional, rutile cored wire for use with either Ar/CO₂ or CO₂. Exceptionally easy to use in all positions, the smooth, stable arc promotes spatter-free welds with smooth tie-ins. The wire is ideally suited for use with ceramic backing for root runs. (Chemical composition; M21 shielding gas). (Mechanical properties of weld metal; M21 shielding gas).

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|-----------------------------------|---|
| Classifications Weld Metal | SFA/AWS A5.36: E71T1-C1A0-CS2-H4 SFA/AWS A5.36: E71T1-M21A0-CS2-H8 EN ISO 17632-A: T 42 3 P C1 1 H5 EN ISO 17632-A: T 46 4 P M21 1 H5 |
| Godkännanden | ABS 4YSA H10 (M21) BV SA3M, SA3YM H10 (C1) BV SA3M, SA3YM H10 (M21) CE EN 13479 CRS 3Y H5S (C1 & M21) CRS 3YS H5 CRS 4YS H10 DB 42.105.07 DNV-GL IV YMS H10 (M21) LR 3YS H10 (M21) NAKS/HAKC 1.2MM PRS 4YS H10 (M21) RIINA 3YS H5 (M21) RIINA 4YS H10 (M21) RS 3Y H5 (M21) VdTUV 04902 |

Godkännanden baseras på fabriken lokaliserings. Vänligen kontakta ESAB för mer information.

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|------------------------|-----|
| Welding Current | DC+ |
| Alloy Type | CMn |

Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|--------------------------|----------------|------------------|------------|
| C1 Shielding gas | | | |
| As Welded | 495 MPa | 585 MPa | 25 % |
| M21 Shielding gas | | | |
| As Welded | 535 MPa | 601 MPa | 25 % |

Slagseghetsdata Charpy V

| Condition | Testing Temperature | Impact Value |
|--------------------------|---------------------|--------------|
| C1 shielding gas | | |
| As Welded | -30 °C | 65 J |
| M21 Shielding gas | | |
| As Welded | -40 °C | 70 J |

Svetsgodsanalys

| C | Mn | Si |
|-------------------------|------|------|
| C1 shielding gas | | |
| 0.06 | 1.20 | 0.40 |

Insmålningsdata

| Diameter | Ampere | Volt | Trådmatningshastighet | Insmålningshastighet |
|----------|-----------|---------|-----------------------|----------------------|
| 1.0 mm | 100-300 A | 22-35 V | 4.5-23 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 |