

## Filarc PZ6138

Well established in the offshore sector, PZ6138 alloyed with 0.9% Ni produces reliable Charpy impact properties down to -60°C and CTOD performance to -10°C. The wire exhibits a smooth stable arc with virtually no spatter.

<b>Classifications Weld Metal</b>	EN ISO 17632-B: T 55 5 T1 M A N2 U H5 SFA/AWS A5.29: E81T1-Ni1M JH4 SFA/AWS A5.36: E81T1-M21A8-Ni1-H4 EN ISO 17632-A: T 50 6 1Ni P M21 1 H5
<b>Godkännanden</b>	ABS 3SA, 3YSA H5 BV S3YM H5 (M21) CE EN 13479 DB 42.105.08 DNV V Y46MS (H5) (M21) GL 6Y46H5S LR 5Y40S H5 (M21) NAKS/HAKC 1.2 mm PRS 3YS H5 (M21) RS 5Y42MSH5 (M21) VdTÜV 04903

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

<b>Welding Current</b>	DC+
<b>Alloy Type</b>	Low alloy

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>M21 Shielding gas</b>			
As Welded	577 MPa	616 MPa	29 %

### Slagseghetsdata Charpy V

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

### Svetsgodsanalys

C	Mn	Si	Ni	Cu
<b>M21 Shielding gas</b>				
0.04	1.1	0.33	0.93	0.021

### Insmätningsdata

Diameter	Ampere	Volt	Trådmatningshastighet	Insmätningshastighet
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