Product Data Sheet FILARC PZ6112

T "Tubular cored electrode arc welding"

Signed by	Approved by	Reg no	Cancelling	Reg date	Page
Neil Farrow	Neil Farrow/Barbro Karlström	EN002552	DCT-90-6112	2004-11-11	1 (2)

GENERAL

An all positional rutile cored wire for weathering steels, used with C1 or M21 shielding gas. Diameters less than 1.4mm are all-positional except vertical down.

Shielding Gas: M21, C1 (EN 439)
Polarity: DC+
Alloy Type: Low alloy
Fill Type: Rutile

CLASSIFICATIONS Weld Metal

EN 758	T 42 2 Z P C 1 H5
EN 758	T 46 2 Z P M 1 H10
SFA/AWS A5.29	E71T-GM H8
SFA/AWS A5.29	E71T1-G H4

APPROVALS

Ü	42.105/2
DB	42.105.13
VdTÜV	06767

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.03	0.07
Si	0.30	0.70
Mn	0.80	1.20
P		0.025
S		0.025
Ni	0.50	0.80
Cu	0.30	0.60

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

	C1 shielding gas, As welded		M21 shielding gas, As welded	
Properties	**Min**	**Max**	**Min**	**Max**
Rp0.2 (MPa)	440		460	
Rm (MPa)	520	610	550	640
A4-A5 (%)	22		22	
Charpy V at -20°C (J)	54		54	
	Comments: Elongation = A5		Comments: Elongation = A5	

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ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed		U	
Ø	Min	Max	Nom	Nom	Min	Max	Min	Max	Min	Max
1.2	150	350	20	85	2.1	7.5	5.8	20.7	27	38

W = Gas consumption (l / min)
η = Recovery, g weld metal / 100g wire (%)
H = Deposit rate (kg weld metal / hour arc time)
Feed = Feeding rate (m/min)
U = Arc voltage (V)