

FILARC PZ6125

FCAW

Type

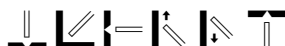
E71 T-5G

Description

All-positional, basic wire for demanding applications, such as offshore fabrication, with dependable CVN toughness down to -50°C and reliable CTOD properties, both AW and SR. Ar/CO₂ gas. Lack of fusion in vertical-up welding is largely avoided by semi-spray arc operation.

Welding current

DC-



Classifications

SFA/AWS A5.29
EN 758

E71 T-5G
T 42 6 1Ni B M 1H5

Typical all weld metal composition, %

C	Si	Mn	Ni
0.07	0.45	1.20	0.85

Typical mech. properties all weld metal

Yield stress, MPa	445
Tensile strength, MPa	556
Elongation, %	28

Charpy V

Test temps, °C	Impact values, J
-40	139
-60	109

Approvals

ABS	3SA,3YSA	Ar/20%CO ₂
BV	S4,5YMHH	Ar/20%CO ₂
CL	956	Ar/20%CO ₂
DNV	VY40MSH5	Ar/20%CO ₂
DS	T 42 6 1Ni B N 1H5	Ar/20%CO ₂
GL	6YH10S	Ar/20%CO ₂
LR	5Y40S	Ar/20%CO ₂
RS	5Y42HHS	Ar/20%CO ₂

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.0	100-250	15
1.2	150-350	20
1.6	150-450	20