FILARC Product Data Sheet

T "Tubular cored electrode arc welding"

FILARC PZ6102

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
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REASON FOR ISSUE

EN ISO Classification updated

GENERAL

A metal cored wire designed for welding with Ar/CO2 shielding gas mixture. Diameters less than 1.4mm are all-positional except vertical down.

Shielding Gas: M21 (EN ISO 14175)
Polarity: DC+

Alloy Type: CMn
Fill Type: Metal cored

CLASSIFICATIONS Weld Metal

SFA/AWS A5.36	E71T15-M21A4-CS1-H4
EN ISO 17632-A	T 46 4 M M21 2 H5

APPROVALS

ABS	3SA, 3YSA H5
BV	S3M, S3YM H5 (M21)
CE	EN 13479
DB	42.105.09
DNV	IV YMS (H5) (M21)
GL	4YH10S (M21)
LR	4Y46S H5 (M21)
VdTÜV	04901

CHEMICAL COMPOSITION

All Weld Metal (%)

M21 shielding gas

	Min	Max
C	0.06	0.09
Si	0.50	0.80
Mn	1.35	1.75
P		0.025
S		0.030
Cr		0.20
Ni		0.50
Mo		0.2
V		0.08
Nb		0.05
Cu		0.3

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

M21 shielding gas

As welded

Properties	Min	Max	Typ
Rp0.2 (MPa)			485
ReL (MPa)	460		
Rm (MPa)	530	630	570
A5 (%)	24		28.9
Charpy V at -40°C (J)	47		75

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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	130	350	20	95	2.0	8.0	4.6	18.5	16	34
1.4	150	380	20	95	1.8	7.0	2.5	9.0	18	34
1.6	150	450	20	95	1.7	7.8	2.0	9.3	17	36

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)