

FILARC PZ6138S SR

An all-positional rutile cored wire for use with carbon dioxide shielding gas, providing very good toughness down to -60°C after stress relief.

Specifications	
Classifications	SFA/AWS A5.29 : E81T1-Ni1C J EN ISO 17632-A : T 46 6 1Ni P C1 1 H5
Approvals	ABS : 5Y42M H5 ABS : 5Y46M H5 ABS : 5YQ420 H5 ABS : 5YQ460 H5 BV : S5Y42H5 BV : S5Y46H5 BV : 5Y42 H5 (C1) BV : 5Y46 H5 (C1) CE : EN 13479 DNV-GL : V Y42MS (H5) (C1) DNV-GL : V Y46MS (H5) (C1) UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Alloy Type	Low alloy
Shielding Gas	C1 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
C1 Shielding gas			
As Welded	498 MPa	579 MPa	28 %
Stress Relieved 2 hour(s) 600 °C	480 MPa	560 MPa	25 %
C1 shielding gas			
As Welded	498 MPa	579 MPa	28 %
Stress Relieved 2 hour(s) 600 °C	480 MPa	560 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
C1 Shielding gas		
As Welded	-60 °C	90 J
Stress Relieved 2 hour(s) 600 °C	-60 °C	83 J
C1 shielding gas		
As Welded	-60 °C	90 J
Stress Relieved 2 hour(s) 600 °C	-60 °C	83 J

Typical Weld Metal Analysis %			
C	Mn	Si	Ni
C1 Shielding gas			
0.05	1.3	0.30	0.90

LOW ALLOY

GAS-SHIELDED FLUX-CORED WIRES (FCAW/MCAW)



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Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	175-350 A	25-38 V	5.6-12.8 m/min	2.8-8.1 kg/h