

FILARC PZ6116S

FCAW

Type Rutile

E81T1-K2 JH4

Description

An all-positional rutile cored wire with good toughness down to -60°C for use with C1 shielding gas. Diameters of less than 1.4mm are all positional, with the exception of vertical down.

Welding current

DC+

Classifications

SFA/AWS A5.29	E81T1-K2 JH4
EN 758	T 46 6 1.5Ni P C 1 H5

Typical all weld metal composition, %

C	Si	Mn	Ni
0.054	0.43	1.38	1.42

Typical mech. properties all weld metal

Yield stress, MPa	553
Tensile strength, MPa	624
Elongation, %	24

Charpy V

Test temps, °C	Impact values, J
-50	69

Approvals

ABS	3SA(H),3YSA(HH)	CO ₂
BV	SA 3YMHH	CO ₂
DNV	V YMS (H10)	CO ₂
GL	6YH5S H5	CO ₂
LR	5Y40S H10	CO ₂
RS	5Y42HHS	CO ₂
PRS	3YH10S	CO ₂

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	150-350	27-35
1.6	150-450	24-40