

## Filarc PZ6500

A copper coated, manganese-silicon alloyed rod for GTAW of all general engineering and structural steels with a minimum yield strength of max 420 MPa. The rod is usually welded with pure argon (I1) as the shielding gas.

| Specifications         |                                                                                |
|------------------------|--------------------------------------------------------------------------------|
| <b>Classifications</b> | EN ISO 636-A : W 42 3 W3Si1<br>EN ISO 636-A : W3Si1<br>SFA/AWS A5.18 : ER70S-6 |
| <b>Approvals</b>       | CE : EN 13479<br>VdTÜV : 11842                                                 |

|                   |                        |
|-------------------|------------------------|
| <b>Alloy Type</b> | Carbon-manganese steel |
|-------------------|------------------------|

| Typical Tensile Properties |                |                  |            |
|----------------------------|----------------|------------------|------------|
| Condition                  | Yield Strength | Tensile Strength | Elongation |
| <b>EN Ar (I1)</b>          |                |                  |            |
| As Welded                  | 470 MPa        | 560 MPa          | 26 %       |

| Typical Charpy V-Notch Properties |                     |              |
|-----------------------------------|---------------------|--------------|
| Condition                         | Testing Temperature | Impact Value |
| <b>EN Ar (I1)</b>                 |                     |              |
| As Welded                         | -30 °C              | 70 J         |

| Typical Weld Metal Analysis % |     |     |       |       |
|-------------------------------|-----|-----|-------|-------|
| C                             | Mn  | Si  | S     | P     |
| <b>Ar</b>                     |     |     |       |       |
| 0.05                          | 1.4 | 0.8 | 0.015 | 0.015 |

| Typical Wire Composition % |      |      |
|----------------------------|------|------|
| C                          | Mn   | Si   |
| 0.078                      | 1.46 | 0.85 |