

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.

Classifications Weld Metal	EN ISO 636-A : W 42 3 W3Si1
Classifications Wire Electrode	SFA/AWS A5.18 : ER70S-6 EN ISO 636-A : W3Si1
Approvals	CE EN 13479 VdTUV 11842

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

Alloy Type	Carbon-manganese steel
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
EN Ar (I1)			
As Welded	470 MPa	560 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
EN Ar (I1)		
As Welded	-30 °C	70 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P
0.05	1.4	0.8	0.015	0.015

Typical Wire Composition %

C	Mn	Si
0.078	1.46	0.85