

FILARC PZ6166

A metal cored wire for the fabrication and repair of Pelton and Francis wheels and other turbine components in 13% Cr 4% Ni alloyed soft martensitic steels used with M13 or M14 shielding gas.

Classifications Weld Metal:	EN 14700:T Fe7, EN ISO 17633-A:T 13 4 M M12 2, EN ISO 17633-A:T 13 4 M M13 2
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Welding Current:	DC+
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M12			
PWHT 580-600°C 8h	681 MPa	835 MPa	18.7 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M12		
PWHT 580-600°C 8h	-20 °C	51 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
M12					
0.021	1.13	0.72	4.43	12.8	0.43

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	150-350 A	18-34 V	5.3-16.4 m/min	2.2-7.0 kg/h