


<b>Technical data sheet</b> EN030225GB	<b>Welding cored wire</b> <b>WA TUB CS 81Ni1</b>	 <b>Welding Alloys</b>
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### CLASSIFICATION

ASME IIC SFA 5.29 / AWS A 5.29: E81T1-Ni1M

### DESCRIPTION

- Rutile flux cored wire for all position welding with slow freezing slag system
- It gives smooth arc with low spatter level
- It provides good weldability with good bead appearance
- Suitable for welding of 590MPa high tensile steel

### APPLICATIONS

Typical applications are machineries, shipbuilding, offshore structures, bridges and general fabrications

### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Ni
0.03	1.4	0.45	0.95

### MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
550	470	19	-30°C: 27

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
630	590	30	-30°C: 130

### SHIELDING GAS

EN ISO 14175: M21 (Ar + 20% CO<sub>2</sub>)

Gas flow rate: 20-25 l/min

### OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]
1.0	DC+	150 - 250	22 - 32
1.2	DC+	180 - 300	24 - 34
1.6	DC+	200 - 380	26 - 36

### WELDING POSITIONS

All positions

### PACKAGING

Diameter	1.0 mm	1.2 mm	1.6 mm
	EN ISO 544 – ASME IIC SFA-5.2 M		
Spool type	BS 300		
Weight	15 kg		

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.