Technical data sheet EN030225GB	Welding cored wire # WA TUB CS 81Ni1	Welding Alloys

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]	A_5 [%]	CVN [J]
550	470	19	-30°C: 27

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
630	590	30	-30°C: 130

SHIELDING GAS

EN ISO 14175: M21 (Ar + 20% CO_2)
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