

E81T1-Ni1

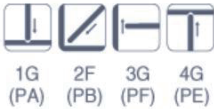
AWS A5.29: E81T1-Ni1M-JH4

AWS A5.36 E81T1-M21A6-Ni1-H4,

Description:

E81T1-Ni1 is designed for gas-shielded flux cored welding of low alloy steels that require good toughness at low temperatures. This alloy is excellent for single and multiple pass, all positional welding with good operation properties like easy slag removal, stable arc, less smoke and spatter etc. Welding for 500MPa grade high strength structural steel, like vessels, machine manufacturing, petrochemical industries and structural bridges etc.

Welding Position:



Diameters:

1.0mm, 1.2mm, 1.4mm, 1.6mm.

Typical Mechanical Properties:

Tensile strength(MPa):	610
Yield strength(MPa):	530
Elongation(%):	25
Impact values(≥ 27)/(-30°C):	103

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	V
0.055	1.35	0.012	0.007	0.40	1.01	--	--	--

Welding Current:(DC+)

Diameter(mm)	1.0	1.2	1.4	1.6
Current/A	60-200	80-300	150-400	180-450
Voltage/V	15-25	15-32	20-40	22-42
Gas speed/(L/Min)	20-25	20-25	20-25	20-25

Note:

- 1.Shield gas: 80% Ar + 20% CO₂
2. Wire extension length: 15-25mm
3. Thermal input: 0.8-1.8KJ/mm, thick plate welding should be preheat.
4. Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.
5. Stock in dry environment, please use up in short time once opened.