

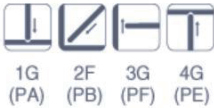
E81T1-Ni2

AWS A5.36 E81T1-Ni2

Description:

E81T1-Ni2 is designed for gas shielded flux cored welding of low alloy steels that require good CVN toughness at low temperatures. It 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 550MPa grade high strength structural steel, like vessels, machine manufacturing, petrochemical industries and structural bridges etc.

Welding Position:



Diameters:

1.2mm, 1.6mm

Typical Mechanical Properties:

Tensile strength(MPa):	610
Yield strength(MPa):	530
Elongation(%):	24
Impact values(≥ 47)/(-20°C):	107

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	V
0.050	1.20	0.012	0.007	0.40	2.10	--	--	--

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: CO₂ ; Gas purity: $\geq 99.95\%$.
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.