

E91T1-Ni2

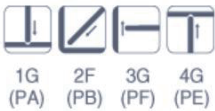
AWS A5.29 : E91T1-Ni2C/M

AWS A5.36 : E91T1-C1/M21A4-Ni2

Description:

E91T1-Ni2 is designed to produce weld metal with increase strength (without being air hardenable) & with increase notch toughness at low temperature. This Nickel steel weld metal can be used without PWHT. Often used in structural applications where excellent toughness is required. Welding for 620MPa 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):	650
Yield strength(MPa):	570
Elongation(%):	23
Impact values(≥ 47)/-20°C):	101

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	V
0.055	130	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.