

# E81T1-Ni2C/M H4

HIGH TENSILE ALLOY STEEL  
FLUX CORED WIRES, DUAL USE



## TYPICAL APPLICATIONS

1. Shipbuilding
2. Offshore structure
3. Structural Fabrication

SIZE	AMPS
1.2mm	100-300A
1.6mm	180-450A

## CHARACTERISTICS

1. Excellent mechanical properties including low temperature toughness at -60 C
2. Premium arc performance and bead appearance.
3. All positional welding capability

## CLASSIFICATION

AWS A5.29 E81T1-Ni2C/M H4  
AWS A5.29 E81T1-M21A4-Ni1-H4  
EN ISO17632-A-T 46 6 2Ni P C1 H4

## WELDING POSITIONS (ISO/ASME)



## MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

Condition	Shielding Gas	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation(%)	Charpy V notch (J)	
AW	100% CO <sub>2</sub>	580	625	25	-40 C	105
	80% Ar+20% CO <sub>2</sub>	585	635	25	-60 C	85
					-40 C	108
					-60 C	90

Note:

- ① Shielding gas: 100% CO<sub>2</sub> or 80% Ar+20% CO<sub>2</sub>; Gas speed 15-25L/Min.
- ② Wire extension length 15-25mm.

## CHEMICAL COMPOSITIONS (Wt%), ALL WELD METAL, TYPICAL

C	Mn	Si	S	P	Ni
0.04	1.21	0.29	0.012	0.015	2.20

## AVAILABLE SIZES (DIA.)

1.2mm/1.6mm

## PACKAGING DETAILS

15kg Spools, Vacuum pack

## CURRENT TYPE

DC+

## EQUIVALENT TO

Lincoln UltraCore 81Ni2      Hyndai SC-81Ni2M  
Esab Tubrod 15.11      Kiswel K-82T  
Indura 81Ni2-V

