

## ❖ Product Description

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|---------------------------------------|-------------------------------------|
| I. Gas shielded, rutile type FCW wire | V. Stable arc and easy slag removal |
| II. Typical 1%Ni weld deposit         | VI. 1.25Cr-0.5Mo type weld deposit  |
| III. Low fumes, very less spatter     | VII. Radiographic weld quality      |
| IV. Excellent mechanical properties   |                                     |

## ❖ Range of Application

- |  |  |
|--|--|
| I. Extremely good for welding of 1.25Cr-0.5Mo, 1Cr-0.5Mo steels  | III. Steam production plants and steam pipes |
| II. Also suitable for 13CrMo44, 15CrMo5, 15Cr3, 16MnCr5, 20MnCr5 |  |

## ❖ Classification

- AWS/SFA 5.29 E81T1-B2C

## ❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	P	Mo	Cr
E81T1-B2C	Min	0.05	-	-	-	-	0.40	1.0
	Max	0.12	1.25	0.80	0.030	0.030	0.65	1.50

## ❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ -30°C
PWHT	550	470	19	-

## ❖ Wire Size & Welding Position

- Diameter in mm- 1.2, 1.6
- Weld Position- All position

## ❖ Current & Gas Flow

- DCEP; 18-25lit/min

## ❖ Packaging

- Standard packaging in 15kg Spool form

### Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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