

❖ 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. Excellent fracture toughness at -30°C |
| III. Low fumes, very less spatter | VII. Radiographic weld quality |
| IV. Excellent mechanical properties | |

❖ Range of Application

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|---|---|
| I. Extremely good for welding of high steels with 1%Ni and equivalent materials | IV. Refineries, power plants e.g. pressure vessels and heat exchangers, machinery |
| II. Construction equipment, off-shore bridges | |
| III. Storage tanks, structural steels | |

❖ Classification

- AWS/SFA 5.29 E81T1-Ni1

❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
E81T1-Ni1	Min	-	-	-	-	-	0.80	-	-	-	-
	Max	0.12	1.50	0.80	0.030	0.030	1.10	0.15	0.35	0.05	1.8

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ -30°C
As Welded	550	470	19	27min

❖ 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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