

ES 81T1-Ni1M

FCAW

ESWECO
The Art of Welding

Type Rutile

E81T1-Ni1M

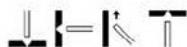
Description

ES 81T1-Ni1M is an all-positional, rutile, flux-cored wire for good toughness down to -40°C . The wire contains 1% nickel and has exceptional operating characteristics in all positions with high deposition rates. Shielding gas Ar + 20% CO_2 or CO_2 . ES 81T1-Ni1M is designed for the all-positional welding of carbon-manganese and low-alloy steels.

Typical applications: offshore fabrications, vessels and structural steel work.

Current

DC+



Classifications

SFA/AWS A5.29
EN 758

E81T1-Ni1M
T 46 3 1Ni P C 2 H5
T 46 4 1Ni P M 2 H5

Typical all weld metal composition, %

C	Si	Mn	Ni
0.06	0.3	1.1	0.9

Typical mech. Properties all weld metal

Yield stress, MPa	560
Tensile strength, MPa	600
Elongation, %	25

Charpy V

Test temps, $^{\circ}\text{C}$	Impact values, J
-40	130

Welding parameters

Diameter, mm

1.2

Welding current, A

110-300

Arc voltage, V

21-32