

RAAJCORED 81-Ni1

Low Alloy Steel Flux Cored Wire for MAG/MIG welding.

CLASSIFICATION : AWS/SFA-5.29: E 81T1-Ni1

CHARACTERISTICS :

- E 81T1-Ni1 is rutile flux cored wires is an all position, single and multi-pass welding on carbon and low alloy steels requiring good toughness at subzero temperature.
- Excellent arc stability and low spatter.
- The slag is easy to remove and slag covering is complete.
- Excellent mechanical properties and weld metal is of radiographic quality

APPLICATION :

- Suitable for welding up to 600N/mm² high tensile steels.
- Also used in bridges, pressure vessels and for 1% Ni and similar steels welding.
- Typical steels welded with this include ASTM A572, A302, A588, and A734
- Ideal for welding quenched & tempered steels

SHIELDING GAS : Welding with CO₂ Gas &/or 75-80% Ar/balance CO₂

CHEMICAL COMPOSITION %

C	Mn	P	S	Si	Ni	Cr	Mo	V
0.12	1.50	0.030	0.030	0.80	0.80-1.10	0.15	0.35	0.05

Single values are maximum

ALL WELD MECHANICAL PROPERTIES

YS (N/mm ²)	UTS (N/mm ²)	Elongation %	CVN Impact Joules
470 min.	550 – 690	19 min.	27 J min. @ -30°C

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min.	Spool packing 12.5 kg.	Spool packing 15 kg
1.20	0.047	120-300	24-30	15-20	√	√
1.60	0.062	180-360	28-36	15-30	√	√

Raajratna offer a wide range of Flux-cored welding wires for MIG welding.

Tailor made packing available on request.