

## RAAJCORED-81 B2

**An all position rutile type flux cored wire for MAG/MIG welding.**

**CLASSIFICATION** : AWS/SFA-5.29: E81 T1 B2  
JIS YF1CM-C

**CHARACTERISTICS** : Flux-cored wire produce weld metal contain 1 Cr- 0.5Mo% for welding high temperatures services and for matching properties of the typical base metals.

**APPLICATION** : for welding 1Cr%-0.5Mo low alloys steels and ASTM A 335-P2 pipe, ASTM A 387 Gr.2 plate.

**SHIELDING GAS** : Welding with CO<sub>2</sub> gas and Ar+ CO<sub>2</sub> gas mixture.

**CHEMICAL COMPOSITION % (Weld Metal Chemistry under CO2 Gas)**

C	Mn	Si	Cr	Mo	S	P
0.65	0.65	0.60	1.30	0.55	0.020	0.022

**ALL WELD MECHANICAL PROPERTIES FOR MIG (under CO2 Gas)**

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL %	SOAKING HOURS
560-640	620-690	20-26	620°C X 1 hrs.

**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	Drum packing 100/200kg
1.20	5/ 64"	120-300	24-34	15-25	√	√	√
1.40	1/ 18"	160-340	26-34	15-25	√	√	√
1.60	1/ 16"	180-360	28-36	15-30	√	√	√

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

Customer packing on request.

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