

# RAAJCORED 81-Ni2

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

**CLASSIFICATION** : AWS/SFA-5.29: E 81T1-Ni2

**CHARACTERISTICS** :

- E 81T1-Ni2 is low alloy steel flux cored wire which produce 2.0-2.25 % Ni in weld deposit give excellent low temperature toughness.
- Good weld bead appearance with stable arc and low spatter
- Slag coverage is complete & slag is easily removable.
- For welding steels which require good tensile strength in the range of 80,000-100,000 psi.

**APPLICATION** :

- For welding steels such as ASTM A572, A575 and A734
- It is suitable for offshore platform construction, storage tanks jobs
- Also used in earthmoving and mining machinery and shipbuilding applications

**SHIELDING GAS** : Welding with CO<sub>2</sub> Gas &/or 75-80% Ar/balance CO<sub>2</sub>

**CHEMICAL COMPOSITION %**

C	Mn	P	S	Si	Ni
0.12	1.50	0.030	0.030	0.80	1.75-2.75

Single values are maximum

**ALL WELD MECHANICAL PROPERTIES**

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	Elongation %	CVN Impact Joules
470 min.	550 – 690	19 min.	27 J min. @ -40°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.