

STRONG FCAW E81T1-B2C

CLASSIFICATION: AWS SFA 5.29 E81T1-B2C

LOW ALLOY FLUX CORED ARC WELDING WIRE



CHARACTERISTICS

STRONG FCAW E81T1-B2C is a rutile type all position low alloy (1.25% Cr - 0.5% Mo) gas shielded flux cored welding wire that gives smooth weld bead, minimal spatter, low fumes, easy slag removal and radiographic quality weld metal.

This wire is suitable for high temperature and pressure service conditions up to 550°C.

APPLICATIONS

STRONG FCAW E81T1-B2C is designed for all position single and multi-pass welding of 1.25Cr-0.5Mo, 1Cr-0.5Mo steels. Joining P4 materials ASTM SA 182/182M Gr.F2/F11/F12, SA 213/213M Gr.T11/T12, SA 335/335M Gr.P11/P12, SA 387/387M Gr.2/11/12.

Suitable for welding application in steam production plants, boiler plants etc.

TYPICAL WELD METAL CHEMISTRY (%)

C	Mn	Si	P	S	Cr	Mo
0.05-0.12	1.25 MAX	0.80 MAX	0.025 MAX	0.025 MAX	1.00-1.50	0.40-0.65

ALL WELD MECHANICAL PROPERTIES

Required as per AWS 5.29	Y.S. MPa	U.T.S. MPa	ELONGATION %
Typical Results PWHT: 690°C for 1 Hr	540	620	25

PACKAGING SPECIFICATIONS - FCAW

DIA SIZE 1.20MM / 1.60MM

SPOOL WEIGHT 15KGS