

ULTRA 81T-1

FLUX CORED WIRE

AWS A/SFA 5.20
E81T-1M

CLASSIFICATION:

- EN ISO 17632 A
- T 55 6 R C/M 2
- T481T1-1CJ
- IS 15769
- ET581RC-1

TYPICAL APPLICATIONS:

- Storage tanks, Structural steel
- General carbon steel fabrication
- Chemical plant machinery, Hulls
- Bridges, Shipbuilding, Towers, Cranes
- Construction equipment manufacturing
- Welding of high tensile steel with strength up to 600 Mpa

KEY FEATURES:

- All position capability
- Radiographic quality weld
- Rutile type gas shielded FCW wire
- Easy slag removal, smooth weld bead
- Suitable for high quality multi-pass welds
- Low fumes, minimal spatter with high deposition rate

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL WT (%):

C – 0.07	Mn – 1.5	Si – 0.5
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MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	UTS, Mpa	YS at 0.2% offset, Mpa	EL%	CVN Impact, J at -
As Welded	610	520	24	58

PARAMETERS & PACKING DATA:

Ø x L mm	Amperage, A
1.2	140-310 220-
1.6	400

DCEP(Electrode Positive)

Use 1-2 volts lower when using mix shielding gas

Available in Vacuum Pack of 15 kg wire layer wounded on Plastic Spool.



DCEP

Electrode Positive

All positions except vertical down



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mix shielding gas**