

ULTRA EL8

SUBMERGED ARC WIRE

AWS A5.29: E91T1-B3C/M
High Strength, Low Alloy Flux Cored Wire

CLASSIFICATION:

- AWS A5.17: EL8
- Low carbon steel wire
- Used with fused or agglomerated fluxes
- Designed for structural welding and pressure vessels

TYPICAL APPLICATIONS:

- Boiler fabrication
- Shipbuilding
- Steel structures
- Bridge construction
- Pressure vessels

KEY FEATURES:

- Smooth arc and stable operation
- Low spatter with uniform bead
- Excellent slag removal
- Good mechanical properties with proper flux
- High deposition rate

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

C – 0.08	Mn – 0.4	Si – 0.1	S/P – ≤ 0.03		
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MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (%)	Impact (J) at -29°C
500	400	26	50

PARAMETERS & PACKING DATA:

Diameter (mm)	Amperage Range (A)
2.5/3.2/4.0	350-800

DCEN(Electrode Negative)

Packed in layer wound spools or drums.
Compatible with multiple flux types

DCEN

Electrode Negative
WELDING POSITION



USE:
For thin sections