

Flux cored wire

Features: Suitable for shipping class steel down to -60°C and CTOD down to -10°C in as-welded

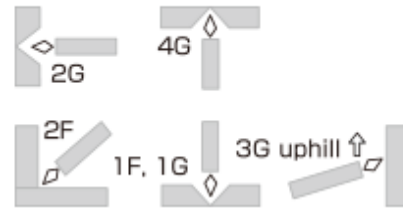
Classification: AWS A5.29 E81T1-K2C

Shielding: CO₂

Polarity: DCEP



Welding Positions:



Packaging data

ϕ mm	Spool
1.2	12.5kg
Volume mm	300W, 110H, 300L

Composition (all-weld metal mass %)

	Typical	Guaranty ^a
C	0.06	0.15
Si	0.32	0.80
Mn	1.38	0.50 - 1.75
P	0.009	0.030
S	0.008	0.030
Ni	1.58	1.00 - 2.00
Cr	0.03	0.15
Mo	0.01	0.35
V	0.02	0.05

Note: ^aSingle values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G	2F	2G	3G uphill, 4G
1.2	150 - 300	150 - 300	150 - 280	150 - 250

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	595	469min.
TS (MPa)	657	552~689
El on 4d (%)	26	19min.
IV -60°C (J)	84	27min.

Approvals

ABS	5YQ460SA H5
BV	SA5Y42M H5
DNV	VY46MS H5
LR	5Y40S H5

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