

OK Tubrod 15.11 FCAW

Type Rutile

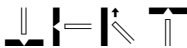
E81T1-Ni2M

Description

A rutile, all-positional, flux-cored, tubular wire containing 2.5 Ni for the welding of mild and medium tensile steels where good notch toughness down to -50°C is required. Extra productivity is available using the spray transfer mode when compared with the traditional basic types using short arc for vertical and overhead welding. All types of fabrication application involving mild and medium tensile steels with a min. yield strength of 510 MPa. This includes shipbuilding and offshore fabrication. Shielding gas: Ar + 20% CO₂.

Welding current

DC+



Classifications

SFA/AWS A5.29	E81T1-Ni2M
EN 758	T 50 6 2Ni P M 2 H5

Typical all weld metal composition, %

C	Si	Mn	Ni
0.05	0.3	0.9	2.3

Typical mech. properties all weld metal

Yield stress, MPa	580
Tensile strength, MPa	620
Elongation, %	24

Charpy V

Test temps, °C	Impact values, J
-50	95

Approvals

DNV	IV Y46MS (H5)	Ar/20%CO ₂
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Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	110-300	21-32