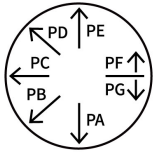


Supercored 81

Classification

AWS AWS A5.29 / ASME SFA-5.29 E81T1-Ni1C
JIS Z 3313 T55 3 T1-1 C A-N2
EN ISO 17632-A T 46 2 1Ni P C1 1
KS D7104 YFW-C602R

Welding Positions



Features

- Designed for welding with 100% CO2 shielding gas
- Smooth and stable arc and good weldability

Polarity

DC +

Application Areas

- General fabrication
- Structural fabrication

Shielding Gas

100% CO2

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Ni
100% CO2	0.03	0.35	1.25	0.011	0.011	0.95

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft · lbs)
100% CO2	570 (83)	640 (93)	25	-30 (-20)	90 (66)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	110~280	Spool 5kg (11lbs), 15kg (33lbs)
1.4 (0.052)	110~280	
1.6 (1/16)	120~300	

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux