



# ESSEN TUB 81B2 SM

**Classification:** **Special product**

Flux-cored wire that deposits a structural CrMo alloy with additions of Ni and V, indicated for welding or rebuilding high-strength steels used in machine components such as high-torsion shafts, where high toughness is required—for example, gears and rolling mill rolls.

Application by the submerged arc welding process. It provides a high deposition rate and a stable arc, resulting in good bead appearance and finish, free of spatter, and excellent slag removal when used with a neutral flux.

## CHEMICAL COMPOSITION:

C	Mn	Si	Cr	Mo	Ni	V
0,05 to 1,0%	1,25% Max.	0,8% Max.	1,0 to 1,5%	0,40 to 0,65%	1,0 to 1,25%	0,2% Max.

## MECHANICAL PROPERTIES:

HARDNESS:	180 to 250 HB
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SHIELDING GAS:	CURRENT TYPE	STICK-OUT (mm):
Not required	DC+	25 to 40

## PRODUCT FEATURES:

DIAMETER (mm):	CURRENT (A):	VOLTAGE (V):	PACKAGING (kg):
2.80	280 a 400	22 a 30	20 (spool) / 200 (drum)
3.20	320 a 480	26 a 34	20 (spool) / 200 (drum)

### CUSTOMER SERVICE POLICY

The information provided above is for reference purposes only and shall not be considered as a guarantee or certificate. Many variables may influence the results of a welding operation. Uniweld Industria de Eletrodos LTDA assumes no responsibility for any incorrect application of the product. If you have any questions, we recommend contacting our Technical Assistance Department for proper support.