



## ESSEN TUB 81T1 B2

**Classification:** AWS A5.29:2010 E81T1-B2 / ASME SFA5.29 E81T1-B2 ED. 25

It is a rutile flux-cored wire for single-pass or multi-pass welding in all positions, recommended for cast steels 1.25Cr/0.5Mo or similar, boiler and heat-resistant tube steels, pressure vessels, heat exchangers in the oil & gas and chemical industries, as well as for the repair of machine components made of CrMo or high-strength steels.

This wire provides a good deposition rate, stable arc, allowing for a smooth bead finish, low spatter levels, and easy slag removal..

### ALLOY TYPE:

C 0,12% máx.	Mn máx 1,25%	Si 0,35 a 0,8%	P 0,03% máx	S 0,03% máx	Cr 1,00 a 1,50%	Mo 0,4 a 0,65%
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### MECHANICAL PROPERTIES:

Tensile Strength: 550 ~ 690 Mpa	Elongation: 19% (min)
Yield Strength: 470 Mpa (min)	Impact (Charpy): Not applicable

WELDING CURRENT:	CC+
SHIELDING GAS:	CO2 100% ou mistura 75% Argônio/25% CO2
STICK-OUT (mm):	15 a 20

### PRODUCT CHARACTERISTICS:

DIAMETER (mm):	AMPERAGE (A):	VOLTAGE (V):	PACKAGING (kg):
Ø 1.2	120 a 280	18 a 30	12.5
Ø 1.6	180 a 320	20 a 34	12.5

#### CUSTOMER SERVICE POLICY

The information above is provided for reference purposes only and should not be considered as a guarantee or certification. Many variables can influence the results of a welding operation. Uniweld Indústria de Eletrodos LTDA is not responsible for any incorrect application of the product. If you have any questions, we recommend contacting our Technical Assistance department for proper support.