



ESSEN TUB 81T1 Ni1

Classification: AWS A5.29:2010 E81T1-Ni1C / ASME SFA5.29 E81T1-Ni1C

Rutile flux-cored wire designed for single-pass or multi-pass welding in all positions, suitable for the fabrication of a wide range of equipment, including mechanical structures, tanks, flanges, and pipes. It is recommended for the maintenance of low-alloy steels where higher weld toughness is required, minimizing the risk of cracking due to embrittlement.

It stands out for its excellent weldability in all positions. It features easy slag removal, contributing to a more efficient welding process, while delivering a weld bead with a high-quality finish.

CHEMICAL COMPOSITION:

C	Mn	Si	P	S	Ni	Cr	Mo
0,12% Max.	1,5% Max.	0,8% Max.	0,03% Max.	0,03% Max.	0,8 to 1,3%	0,15% Max.	0,35% Max.

MECHANICAL PROPERTIES:

TENSILE STRENGTH:	YIELD STRENGTH:	ELONGATION:	IMPACT TOUGHNESS:
550 ~ 690 Mpa	470 Mpa (min)	19% (min)	27 J to -30°C

SHIELDING GAS:	CURRENT TYPE	STICK-OUT (mm):
CO2 100%	DC+	15 to 20

PRODUCT FEATURES:

DIAMETER (mm):	CURRENT (A):	VOLTAGE (V):	PACKAGING (kg):
1.20	120 to 280	18 to 30	12.5
1.60	180 to 320	20 to 34	12.5

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.