



# AUTOMIG FC 81T1-Ni1

AWS A/SFA 5.29 E81T1-Ni1C

FCAW LOW ALLOY STEEL (Low Temperature)

### CLASSIFICATION:

EN ISO 17632-A  
T 46 3 1Ni P C1 2

### KEY FEATURES:

- Rutile type gas shielded FCW wire
- Typical 1%Ni weld deposit
- Stable and smooth arc
- Low fumes, Minimal spatters
- Easy slag removal, smooth weld bead
- Excellent fracture toughness at -30°C
- Radiographic quality weld

### APPROVALS: CE

### TYPICAL APPLICATIONS:

- Welding of high tensile steel 1% Ni steel and equivalent materials
- Storage tanks for low temperature
- Offshore application, Bridges
- Refineries, power plants e.g. pressure vessels and heat exchangers, machinery


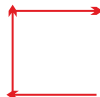
### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Ni
0.06	1.2	0.5	1.0

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	As Welded	600	520	22	50

### PARAMETERS - PACKING DATA:

Ø, mm	Net Wt, Kg	
1.2	15	 <b>DCEP</b> All Positions, Except Vertical Down  <b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box
1.6	15	

Shielding Gas	Gas Flow Rate, LPM
CO <sub>2</sub>	15-20