BW-81T

Flux Cored Welding Wire

For 550N/mm² class high tensile strength steel

AWS A5.29 E81T-1-Ni1M

Applications & Features

For butt & fillet welding of 550N/mm² high tensile strength steels of structures such as ships, bridges, building and storage tanks etc.

Characteristics

(1) BW-81T is a titania type flux cored wire designed for all positional single & multi pass welding with Argon/CO_2 mixed shielding gas.
(2) It provides excellent usability with a stable arc, less spatter, good bead appearance, excellent slag removal and minimal welding fumes as compared to solid wire.
(3) Provides excellent welding efficiency due to high deposition rates.

Notes on Usage

(1) The optimum flow for shielding gas is 20~25ℓ/min.
(2) The distance between tip & base material is to be 20~25mm.
(3) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec & more.
(4) Thick heavy plate should be welded under proper preheating & interpass temperatures

Approvals

ABS

Part Numbers:

2094 (1.2mm x 15kg spool),
2094P (1.2mm x 200kg pail pack),
2095 (1.6mm x 15kg spool)

Typical chemical composition of weld metal (%) *(Shielding Gas: Argon/CO_2 mix)*

C	Mn	Si	P	S	Ni
0.05	1.30	0.40	0.013	0.011	0.95

Typical mechanical properties of weld metal *(Shielding Gas: Argon/CO_2 mix)*

YP	TS	EL	IV (J)	
N/mm²(MPa)	N/mm²(MPa)	%	-20°C	-30°C
538	605	29.4	124	81

Size & recommended current range (DC+)

	Dia. mm (in)	1.2 (0.045)	1.4 (0.052)	1.6 (0.062)
Amp	Flat, H-Fillet	180-340	200-360	200-400
	Vertical Up	120-220	140-260	160-260
	Vertical Down	120-240	140-260	160-280
	Overhead	120-220	140-260	160-260