

GFC 81

IDENTIFICATION

GFC 81, E81T-1C

CLASSIFICATION

AWS/SFA 5.29: E81T-1C

DESCRIPTION

Tubular rutile flux-cored all position wire for single or multipass welding of carbon, carbon-manganese steels and similar types of steels, including fine grain ones, with CO₂ shielding gas. The good weldability in all positions, excellent bead appearance, less spatter, a fast freezing and easy to remove slag.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni
0.04 - 0.10	0.90 - 1.50	0.30 - 0.65	0.030 max	0.030 max	0.60 min

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
560 min	490 min	22 - 30	0°C	50 - 100

TYPICAL APPLICATIONS

Ship building, railways wagons, general fabrication welding, Pipe welding, bridges, automobile parts, tanks etc.

Welding of high tensile steel offshore structure, etc.

SHIELDING GAS : CO₂

FLOW RATE : 15 - 20 l/min

PACKING PARAMETERS

Size (mm)	Amps DC (+)	Voltage (V)	Stick out (mm)	Weight / Spool (kg)
1.2	150 - 280	23 - 29	15 - 20	15