

GFC 81A1

LOW ALLOY FLUX CORED WIRE

IDENTIFICATION

GFC 81A1, E81T1-A1C

CLASSIFICATION

AWS/SFA 5.29: E81T1-A1C,
ASME - IIC/SFA-5.29-E 81T1-A1M

DESCRIPTION

Tubular rutile flux-cored wire for single or multipass welding of 0.50 Mo heat resistant steels used for steam pipes of boilers of thermal power plant and similar types of steels, with CO₂ shielding gas. The good weldability in all positions, excellent bead appearance, less spatter, a fast freezing and easy to remove slag. Deposited welds arc of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Mo
0.12 max	0.50 - 1.25	0.30 - 0.80	0.030 max	0.030 max	0.40 - 0.65

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)
560 min	490 min	19 min

After PWHT of a) 620 ± 15°C / 1 hour. b) 690 + 15°C / 1 hour TYPICAL APPLICATIONS

- ASTM A 336 F1, A 204 A,B,C
- DIN 15Mo3 (1.5415)
- ASTM A 217 WC1, A 352 LC1
- BS 3059 Grade 243
- ASTM A 335 Grade P 1
- C-Mn steel where higher tensile strength is required.
- Chemical process plant.

SHIELDING GAS : CO₂ / Ar + Co₂ (80% + 20%)

FLOW RATE : 14 - 20 l/min

PACKING PARAMETER

Size (mm)	Amps DC (+)	Weight / Spool (kg)
1.2	120 - 250	15
1.6	180 - 350	15