

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