

GFC 81B2

LOW ALLOY FLUX CORED WIRE

IDENTIFICATION

GFC 81B2, E81T1-B2C

CLASSIFICATION

AWS/SFA 5.29: E81T1-B2C,
ASME - IIC/SFA-5.29-E81T1-B2C

DESCRIPTION

Tubular rutile flux-cored wire for single or multipass welding of 1.25 Cr - 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	Cr	Mo
0.05 - 0.12	0.50 - 1.25	0.30 - 0.80	0.030 max	0.030 max	1.0 - 1.50	0.40 - 0.65

MECHANICAL PROPERTIES (RANGE)

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

After PWHT of 690 ± 14°C/ 1 hour. TYPICAL APPLICATIONS

Power Plant equipments, pipes and Cr-Mo steels having requirements of high creep resistance.

ALLOYED STEEL : ASTM, A335 Grade P11 and P12 or equivalent.

SHIELDING GAS : CO₂

FLOW RATE : 14 - 20 l/min

PACKING PARAMETERS

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