

GFC 81Ni2

IDENTIFICATION

GFC 81Ni2, E81T1-Ni2

CLASSIFICATION

AWS/SFA 5.29: E81T1-Ni2

DESCRIPTION

GFC 81Ni2 is designed for welding of 590 MPa high tensile steel with slow freezing slag system. Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications. 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	Cr	P	Ni	Mo
0.12 max	1.50 max	0.39 max	0.03 max	0.04 max	0.03 max	1.75 - 2.75	0.35 max

MECHANICAL PROPERTIES (RANGE)

PWHT	TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
				Temp	Joules
As welded	600 min	530 min	19 min	-50°C	40 min

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	Weight / Spool (kg)
1.2	180 - 300	24 - 36	15