

GFC 81W2

IDENTIFICATION

GFC 81W2, E81T1-W2

CLASSIFICATION

AWS/SFA 5.29: E81T1-W2C

DESCRIPTION

Tubular rutile flux-cored wire for single or multi-pass welding of weathering steels such as Corten A, Corten B 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 weld metal has good corrosion resistance against atmosphere.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Cu
0.12 max	1.30 max	0.45 max	0.03 max	0.03 max	0.45 - 0.70	0.40 - 0.80	0.42 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
595 min	540 min	19 min	-30°C	45

TYPICAL APPLICATIONS

- Ship building, railways wagons, general fabrication welding, pipe welding, bridges, power plant structures, chimney, etc.
- For welding A588 steel

SHIELDING GAS : CO₂

FLOW RATE : 14 - 20 l/min

PACKING PARAMETERS

Size (mm)	Amps DC (+)	Weight / Spool (kg)
1.2	120 - 300	15
1.6	180 - 450	15