GeKa®

Seamless Rutile Type Flux Cored Wire

ELCOR R 81 Ni SC

Standards

TS EN ISO 17632-A	: T50 3 1Ni P M 1 H5 / T 46 4 1Ni P C 1 H5
EN ISO 17632-A	:T50 3 1Ni P M 1 H5 / T 46 4 1Ni P C 1 H5
AWS A5.29	: E 81T1-Ni1C, Ni1M H 4

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Ni
0.05	0.5	1.30	0.90

Mechanical Properties - (Typical): (With CO_2 gas)

Heat Treatment	Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-30°C) (with M21 gas)	Impact Strength (ISO-V/-40°C) (with CO_2 gas)	Elongation ($(L_o=5d_o)$ (%)
AW	min. 460	530 - 680	min. 47 J	min. 47 J	min. 22

AW: as welded

Typical Base Material Grades

- EN: S 185, S235-S355, P 235 GH, P 265 GH, P 295 GH, P 235 T1/T1-P 355 N, L210-L485, S255-S500 (NL1,2), X 42-X80
  ASTM: A 131, A 106/A515/A714, A 283/A285/A414/A662/A372, A369/A210/A106/A516/A573/A707, A516/A255/ A299/ A333/ A350/ A612

Features and Applications

- Micro-alloy rutile flux-cored wire with rapidly solidifying slag for CO_2 and Ar+CO_2 mix.
- Excellent weld puddle manipulation, superior all-position welding
- Using temperature up to -60°C
- Particularly suited for MAG orbital welding applications and all-positipon welding on ceramic backing. Low spatter loss, easy slag removel
- CTOD tested for offshore applications
- Shielding Gases: CO_2 or M21

Welding Positions

Current Type

FCAW / D.C.(+)

Operating Data

Diameter (mm)	Diameter (inch)	Weight (Kg)	Package Type
1.20	0.047”	15	D 300