ELCOR R 81 Ni

Standards

TS EN ISO 17632-A	: T 46 4 1Ni P C 1
EN ISO 17632-A	: T 46 4 1Ni P C 1
AWS A5.29	: E81 T1-Ni1 C

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/-40°C)	Impact Strength (ISO-V/-30°C)	Elongation ($(L_o=5d_o)$ (%)
AW	min. 470	560 - 690	50 J	80 J	min. 24

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

- Rutile type flux cored welding wire with good toughness in mild and 490-550 MPa high tensile steels at low service temperatures
- Suitable for butt and fillet welding in all positions
- You can get smooth arc, and low spatter, good weldability
- Shielding Gas: CO_2

Welding Positions

Current Type

FCAW / D.C.(+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500337	1.20	0.047”	15	BS 300

Approvals: ABS, CE, SEPRO, TL