



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN FC 81T1

Review: 01

STANDARD: AWS A5.29: 2010 E81T1-W2C / ASME SFA5.29 E81T1-W2C Edition 2015 **Date: 07/2016**

Chemical characteristic of the deposited metal	C	Mn	Si	P	S	Cr	Ni	Cu
	0.12% Max.	0.50% 1.30%	0.35 The 0.80%	0.030% max.	0.030% max.	0.45 to 0.70%	0.40% to 0.80%	0.30 to 0.70%

APPLICATION FIELD	It is a cored wire Rutile for welding in a single pass or multipass in all positions indicated for resistant weathering steel corrosion, heavy construction in general and maintenance shops generally being suitable for industries cement, ceramics, mining, steelworks, petrochemical, Sugar and Alcohol and etc.																				
TECHNICAL CHARACTERISTICS	This wire obtains a good deposition rate, stable arc, allowing a good finish of the cord, low splash index, easy removal of the slag and providing and facilitating efficiency in operation.																				
MECHANICAL PROPERTIES	Tensile strength: 550 -690 MPa Flow limit: 470 MPa (min) Stretching: 19% (Min) Impact Test: 75 J at - 30° C																				
OPERATIONAL CHARACTERISTICS	Type of current: CC +																				
	welding position: All the positions																				
	shielding gas: 100% CO2																				
	Stick-out: 15 to 22mm																				
	<table border="1"> <thead> <tr> <th>Diameter (mm)</th> <th>Ø1,20</th> <th>Ø1,60</th> <th></th> <th></th> </tr> </thead> <tbody> <tr> <td>Amps (A)</td> <td>120 0320</td> <td>180-350</td> <td></td> <td></td> </tr> <tr> <td>Voltage (V)</td> <td>22 to 30</td> <td>22 to 30</td> <td></td> <td></td> </tr> <tr> <td>Packing</td> <td>15</td> <td>15</td> <td></td> <td></td> </tr> </tbody> </table>	Diameter (mm)	Ø1,20	Ø1,60			Amps (A)	120 0320	180-350			Voltage (V)	22 to 30	22 to 30			Packing	15	15		
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WELDING TECHNIQUE	Make cleaning the area to be welded with grinder or using mechanical rotary brush impregnated with mill scale and impurities must be removed not to cause contamination, making the appropriately adjusting the amperage and voltage of the machine according to the diameter to be used to avoid overloading the tank wire and regulate the flow of gas.																				