

	UNIWELD IND. DE ELETRODOS LTDA Address: 1788, XV de Dezembro Avenue – Tanque do Moinho Zip Code: 12.910-691 – Bragança Paulista – São Paulo – Brazil Phone: (+55 11) 4035-8877 E-mail: uniweld@uniweld.com.br Website: www.uniweld.com.br	Contact Uniweld (+55 11) 4035-8877

COMMERCIAL NAME: ESSEN FC 81T1 Ni1 Review: 01
STANDARD: AWS A5.29: 2010 E81T1- Ni1C / ASME SFA5.29 E81T1- Ni1C Edition 2015 Date: 06/2018

Chemical characteristic of the deposited metal	C 0.12% Max.	Mn 1.50% Max.	Si 0.80% Max.	P 0.030% max.	S 0.030% max.	Cr 0.15% Max.	Ni 0.80% The 1.10%	Mo 0.35% Max.	V 0.050% max.
---	---------------------------	----------------------------	----------------------------	----------------------------	----------------------------	----------------------------	------------------------------------	----------------------------	----------------------------

APPLICATION FIELD	Suitable equipment for the manufacture of mechanical structures such as tanks, pipes and flanges.																				
TECHNICAL CHARACTERISTICS	cored wire with excellent weldability in all positions, good rate of deposition, easy slag removal and smooth finish of the cord.																				
MECHANICAL PROPERTIES	Tensile strength: 620 MPa Flow limit: 515 MPa Stretching: 24% (Min) Impact Test: 75 J at - 30 ° C																				
OPERATIONAL CHARACTERISTICS	Type of current: CC + welding position: All the positions shielding gas: 100% CO2 (15 to 25 Lts. / Min.) Stick-out: 15 to 22 mm <table border="1"> <tr> <td>Diameter (mm)</td> <td>Ø1,20</td> <td>Ø1,60</td> <td></td> <td></td> </tr> <tr> <td>Amps (A)</td> <td>120-320</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>Packaging (kg)</td> <td>15</td> <td>15</td> <td></td> <td></td> </tr> </table>	Diameter (mm)	Ø1,20	Ø1,60			Amps (A)	120-320	180-350			Voltage (V)	22 to 30	22 to 30			Packaging (kg)	15	15		
Diameter (mm)	Ø1,20	Ø1,60																			
Amps (A)	120-320	180-350																			
Voltage (V)	22 to 30	22 to 30																			
Packaging (kg)	15	15																			
WELDING TECHNIQUE	Removing impurities from the area to be welded, using grinder or mechanical brush, avoiding contamination. Regular equipment condition as amperage, voltage, gas flow and stick out looking for the ideal parameters of application.																				