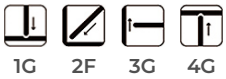
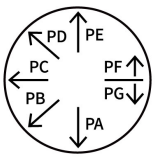
SL-81MAG

Classification

AWS AWS A5.29 E81T1-Ni1M-J
EN ISO 17632-A T50 6 1Ni P M21 1 H5

Welding Positions





Features

- Designed for welding with Ar+20~25%CO2 shielding gas
- Prevents the weld from hydrogen induced cracking or cold cracking

Polarity

DC +

Application Areas

- Shipbuilding
- Steel construction
- Offshore

Shielding Gas

Ar+20~25% CO2

Approvals

DNV
✓

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Ni
Ar+20~25% CO2	0.03	0.40	1.26	0.017	0.002	0.86

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
Ar+20~25% CO2	586(84)	634(91)	25	-40(-40) -60(-76)	112(83) 92(68)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	120~300	Spool 5kg(11lbs), 12.5(27.6lbs), 15kg(33lbs)
1.4 (0.052)	150~350	
1.6 (1/16)	150~360	