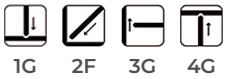
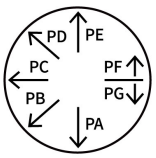
Supercored 81-K2

Classification

AWS AWS A5.29 / ASME SFA-5.29 E81T1-K2C H4
JIS Z 3313 T55 6 T1-1 C A-N3
EN ISO 17632-A T46 6 1.5Ni P C1 1 H5
KS D7104 YFL-C506R

Welding Positions





Features

- Designed for welding with 100%CO2 shielding gas
- Good impact value at low temperature
- Low hydrogen level (H4)

Polarity

DC+

Application Areas

- Shipbuilding
- LPG storage tank
- Offshore structure

Shielding Gas

100% CO2

Approvals

ABS	BV	CCS	DNV	KR	LR	NK	RINA	RS	CWB	CE
✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓

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

Shielding Gas	C	Si	Mn	P	S	Ni
100% CO2	0.04	0.35	1.35	0.010	0.010	1.50

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)
100% CO2	540(78)	620(90)	28	-30 (-20) -60 (-75)	110(81) 60(44)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	110~280	Spool 5kg (11lbs), 12.5kg (28lbs), 15kg (33lbs), 20kg (44lbs) Drum 100kg (221lbs), 200kg (441lbs), 250kg (551lbs)
1.4 (0.052)	110~280	
1.6 (1/16)	120~300	