DW-A81Ni1 TRUSTARC™

Flux cored wire

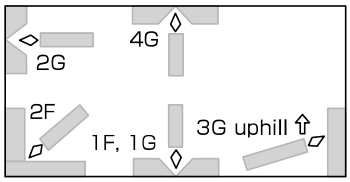
Features:
- Excellent impact values down to -60℃
- Meets the NACE MR0175 requirements for both chemistry and hardness. The nickel content is normally 1% max.

Classification: AWS A5.29 E81T1-Ni1M-J

Shielding gas: Ar-20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	15kg
Volume mm	300W, 110H, 300L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.06	0.12
Si	0.35	0.80
Mn	1.30	1.50
P	0.009	0.030
S	0.008	0.030
Ni	0.91	0.80~1.00
Cr	0.02	0.15
Mo	0.01	0.35
V	0.02	0.05

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill, 4G
1.2	150~300	150~280	150~250

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	520	469min.
TS (MPa)	580	552~689
El on 4d (%)	29	19min.
IV -60℃ (J)	142	27min.

Approvals

ABS	5YQ420SA (H5) 4Y400SA (H5), MG
LR	5Y42S, H5
DNV	VY42MS (H5)
CWB	E551T1-Ni1MJ-H8 (E81T1-Ni1MJ-H8)