

BT 81T1-Ni1M FLUX CORED MIG WIRE

KEY FACTS

- ◆ AWS A5.29 E81T1-Ni1M
- ◆ Perfect for offshore industry
- ◆ Low-alloy steel flux-cored
- ◆ Designed for Ar/CO² gas mixes for lower operating cost
- ◆ Superior weldability, low spatter, good bead appearance
- ◆ Outstanding operators appeal
- ◆ Vacuum sealed for long life

DESCRIPTION

BT 81T1-Ni1M is a low temperature rutile cored, carbon steel flux-cored MIG wire designed for single or multi pass using Argon /CO₂ shielding gas welding having a smooth spray-type transfer commonly used on low alloy steels.

Specific design for stress relieved applications, guaranteed impact properties after PWHT. Featuring superior weldability, low spatter, good bead appearance and outstanding operators appeal.

Titanium Oxide slag system with excellent weld-ability & bead appearance. Contains 1% Ni for the steel welding of 590N/mm² high tensile steel with requirement of low temperatures down to -30°C.

CLASSIFICATIONS, APPROVALS, CONFORMANCES

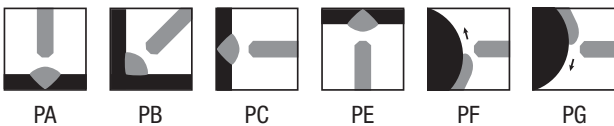
AWS A5.29 E81T1-Ni1M

RECOMMENDED SHIELDING GAS

75-25% Ar/CO² gas mixes

WELDING POSITIONS

All positions except vertical down



APPLICATIONS

Superior product consistency with optimal alloy control and welding structures with low temperature requirements such as:

- ◆ Ships and Storage Vessels
- ◆ Construction Machinery
- ◆ Offshore Fabrication
- ◆ NACE applications
- ◆ Bridge Structures
- ◆ Storage Tanks
- ◆ Mining Equipment
- ◆ Weathering steels

TYPICAL WIRE ANALYSIS

C Carbon	Mn Manganese	Si Silicon
< 0.12	< 1.50	< 0.80
Ni Nickel	S Sulphur	P Phosphorus
0.80 - 1.10	< 0.03	< 0.03

TYPICAL WELD MECHANICAL PROPERTIES

Yield Strength	MPA > 470
Tensile Strength	MPA 550 - 690
Elongation	> 19%
Impact Strength	27 J @ -20°C

PACKAGING & ORDERING INFORMATION

Size	Packet	Part Number
1.2mm	15kg	200270
72 spools /pallet		

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products; this is entirely up to the user's ability.