

CODIFICATION: AWS/SFA 5.29 EN ISO 17632-B
E81T1-B2M T55ZT1-1MP-G

CHARACTERISTICS AND APPLICATIONS:

Maxfil-81R is an all position low alloy steel flux cored wire designed for welding of 1.25% Cr-0.5% Mo steel with high temperature and pressure service conditions in steam pipes and boilers. The slag coverage is complete and easy to remove. This wire burns with low spatter & minimal fumes with radiographic quality deposits.

Maxfil-81R is designed for single and multi-pass welding of similar composition steels and equivalent grade steels like; Gr. F2/F11/F12 of SA-182, Gr. T11 of SA-199, Gr. T2/T11/T12 of SA-213, Gr. WC6 of SA-217, Gr. P2/P11/P12 of SA-335, Gr. FP2/FP11/FP12 of SA-369, Gr. 2/11/12 of SA-387, Gr. CP2/CP11/CP12 of SA-426.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

Element	C	Mn	Si	S	P	Cr	Mo
Range	0.05-0.12	1.25	0.80	0.030	0.030	1.00-1.50	0.40-0.65
Typical	0.062	0.80	0.40	0.012	0.017	1.25	0.52

MECHANICAL PROPERTIES OF ALL WELD METAL:

Property	UTS (MPa)	YS (MPa)	% El (L=4d)
Range	550-690	470 Min	19.0 Min
SR : 690°C/1Hr	600	520	25.0

WELDING POSITIONS: H, F, VU, OH

WELDING PARAMETER: DC (+)

Diameter (mm)	HORIZONTAL/FLAT		VERTICAL UP		OVERHEAD	
	Volt, V	Current, A	Volt, V	Current, A	Volt, V	Current, A
1.20	26-32	160-260	22-26	100-160	24-28	100-160
1.60	26-32	180-300	22-26	110-200	24-28	110-200

APPROVALS:

CE MARKING

SHIELDING GAS:

➤ Argon - Carbon Dioxide CO₂ (80:20%) at flow rate 12-15 litres per minute.

PACKING:

Standard size : 1.20 & 1.60mm. Other diameters may be available on request.
Quantity : Supplied approximately 15Kgs in a plastic spool. Each spool is sealed in an air tight polythene bag and then packed in a corrugated box.

AUTHORISED DISTRIBUTOR - SALES & SERVICE

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