

PRODUCT DATA SHEET

Coremax 81K2



Coremax 81K2 is a Titania type flux cored wire designed for welding 400-490 MPa high tensile steel for low temperatures. The weld metal contains about 1,5% nickel and has excellent notch toughness at temperatures down to -600°C under as welded conditions. It provides excellent usability and efficiency in all positions welding with CO_2 gas. It is suitable for butt or fillet welding on offshore structures for low temperature areas, LNG and LPG carriers, and storage tanks.

Classifications

AWS	A5.29	E81T1-K2
EN	17632-A	T50-6-1.5Ni-B-C-2-H5
EN	17632-B	T57-6-N3-C-T4-I-H5

Chemical Analysis

	100% CO_2		100% CO_2
% Carbon	0,03	% Sulphur	0,009
% Manganese	1,47	% Molybdenum	0,014
% Silicon	0,47	% Phosphorous	1,58

Typical Mechanical Properties (All weld metal in the as welded condition)

	100% CO_2
Yield Strength	580 MPa
Tensile Strength	620 MPa
% Elongation on 5d	28
Charpy V-Notch -60°C	49 J

Packing Data (DC+)

Diameter (mm)	Current (A)	Pack Mass (kg)	Item Number
1,2 Flat & Horizontal	130 - 300	15,0 (spool)	W081149
1,2 Vertical & Overhead	130 - 240		
1,6 Flat & Horizontal	200 - 350	15,0 (spool)	W081150
1,6 Vertical & Overhead	160 - 220		

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