

TM811-A1



TM 811-A1 deposits a weld metal containing 0,5% Mo it is designed for welding creep resistant steels for service up to 500°C. TM 811-A1 offers good weldability in all positions, with a fast freezing slag that removes easily. The wire is recommended for single and multi pass welding in all positions using either 100% CO₂ or Fluxshield shielding gases.

CLASSIFICATION

AWS A5.29 E81T1-A1

CHEMICAL ANALYSIS (TYPICAL)

% Carbon	0.04	% Sulphur	0.016
% Manganese	0.83	% Phosphorous	0.014
% Silicon	0.26	% Molybdenum	0.48

**TYPICAL MECHANICAL PROPERTIES
(ALL WELD METAL IN THE AS
WELDED CONDITION)**

Yield Strength	572 MPa
Tensile Strength	648 MPa
Elongation on 5d	26%
Charpy V-Notch	N/A

PACKING DATA

DC+

Diameter (mm)	Volts	Amps	Deposition Rate Kg/Hr	Item Number	Pack Mass (Kg)
1.2	20	115	1.2 to 6.6	081-018	15 Kg Spool
	28	275			
	30	325			

Bold indicates optimum parameters for welder appeal.
Recommended shielding gas: 100% CO₂ or Afrox Fluxshield.

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