

PRODUCT DATA SHEET

Trimark TM811-A1



TM 811-A1 deposits a weld metal containing 0,5% Mo, and 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.

Classifications

AWS	A5.29	E81T1-A1
EN	17634-A	T Mo P C2 H10
EN	17634-B	T 55 T1-2M3-H10

Typical Chemical Analysis

% 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

Diameter (mm)	Current		Deposition Rate (kg/hr)	Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)			
1,2	20	115	1,2 - 6,6	15 (spool)	W081018
	28	275			
	30	325			

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

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