Supercored 81MAG

TYPE : Rutile

AWS A5.29 / ASME SFA5.29 E81T1-Ni1M H4
EN ISO 17632-A-T 46 6 1 Ni P M 2 H5

Applications

Supercored 81MAG can be used in oil and gas construction, pipe, and offshore structures.

Characteristics on Usage

Supercored 81MAG is a rutile type flux cored wire to be used with Ar+ CO_2 gas mixture shielding. This provides excellent notch toughness at low temperature, not only as-welded but also in stress relieved condition.

Notes on Usage

1) Proper preheat and interpass temp. (50-150°C) must be used in order to release hydrogen which may cause cracking in welds when the wire is used for medium and heavy plates.
2) Use Ar+20~25% CO_2 gas.

Welding Position	Current	Shielding Gas
 1G (PA) 2F (PB) 3G (PF) 4G (PE)	DC +	Ar+20~25% CO_2

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.05	0.28	1.20	0.008	0.012	0.93

Typical Mechanical Properties of All-Weld Metal

YS MPa	TS MPa	EL (%)	Temp. °C	CVN-Impact Value J	
550	590	26	-60	60	As welded
510	570	28	-40	98	PWHT(620°Cx2hr)

Approval

ABS, BV, DNV, LR, CWB, RINA, MRS, TÜV, DB, CE

Packing

Dia. (mm) 1.2 1.6

Spool(kg) 15

Sizes Available and Recommended Currents (Amp.)

Size, mm	1.2	1.6
F & HF	200~290	260~350
V-up,OH	180~250	230~290
V-down	210~280	270~330

Diam.	15kg Spool
1.6mm	HKSCORD8116

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