



AUTOMIG FC 81T1-K2

AWS A/SFA 5.29 E81T1-K2C

FCAW LOW ALLOY STEEL (Low Temperature)

CLASSIFICATION:

EN ISO 17632-A
T 46 3 1.5Ni P C1 2

KEY FEATURES:

- Rutile type gas shielded FCW wire
- Stable and smooth arc
- Low fumes, Minimal spatters
- Easy slag removal, smooth weld bead
- Improved impact properties
- Suitable for medium to high strength applications
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding high strength, fine grained structural steels like N-A-XTRA 55, N-A-XTRA 60, LA60, Sailma 450/450HI
- Structural applications where low temperature toughness is required
- Suitable for joining HY 80, HY 100, ASTM A710, A514 steels and similar high strength materials
- Offshore structures and structural applications



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Ni
0.07	1.4	0.5	1.3

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	As Welded	605	510	22	50

PARAMETERS - PACKING DATA:

Ø, mm	Net Wt, Kg	
1.2	15	 DCEP All Positions, Except Vertical Down  STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box
1.6	15	

Shielding Gas	Gas Flow Rate, LPM
CO ₂	15-20