

K-81TW

For atmospheric corrosion resisting steel

Classifications

EN ISO 17632-B:2008	: T55 3 T1-1CA-NCC1 H10	AWS A5.29-10	: E81T1-W2C
JIS Z 3320	: T55 3 T1-1CA-NCC1 H10	AWS A5.36-12	: E81T1-C1A2-W2-H8
		KS D 7109	: YFA-58W

Description

- It is designed for welding of 560MPa weather-proof steels
- It has better CVN toughness at low temperatures when compared to the K-71TW
- Wire is a titania type of flux cored wire for all-position welding
- It feature excellent mechanical properties, easy slag removal, low spatter generation, high X-ray safety

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	Cu
CO ₂	0.05	0.54	1.20	0.55	0.55	0.45

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20℃	-30℃	
AWS A5.29	min. 470	550~690	min. 19		≥ 27	
EN ISO 17632-B	min. 460	550~740	min. 17		≥ 27	
Example	550	630	28	75	60	CO ₂

Notes on usage and welding condition

- Refer to page 211~213 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input

Package

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	5, 12.5, 15, 20		
Pailpack (kg)	100 ~ 300		