



KISWEL

KISWEL – K-81TB2

Classifications:

AWS A5.29: E81T1-B2C

JIS Z 3183: T55 T1-1C-1CM

AWS A5.36: E81T1-C1PZ-B2

EN ISO 17634-A: T CrMo1 P C 1

Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	Cr	S	Mo
0.05 – 0.12	<0.80	<1.25	1.00 – 1.50	<0.025	0.40 – 0.65

Description:

- For welding 1.25%Cr-0.5%Mo heat-resistant steel for fabrication of high pressure vessels and Piping systems.
- Excellent welding characteristic with low spatter and easy to remove slag.

Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)
min. 460	min. 550	min. 10

Welding Parameters:

Wire Diameter	Welding Position	Shielding Gas	Current (A)		Voltage (V)	
			Min.	Max.	Min.	Max.
1.20 mm	F, HF	CO ₂	220	280	25	30
1.20 mm	VU		200	240	25	28
1.20 mm	OH		160	220	23	28



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