MIDALLOY MASTERCOR E81T1-B2C, B2M FLUX-CORED WIRE

CLASSIFICATION

- AWS 5.29 Class E81T1-B2C, B2M / ASME SFA 5.29 Class E81T1-B2C, B2M

DESCRIPTION

- MIDALLOY MASTERCOR E81T1-B2C, B2M flux-cored wire is an "out of position" flux-cored wire, particularly suited for pipe welding.
- This wire can be used for single or multiple pass welding.

APPLICATIONS

- For joining applications welding low alloy ferritic creep resisting steels of the 1 Cr/½ Mo and 1½ Cr/½ Mo types.
- Common materials include ASTM A199, A209, A213 (cast), A217 WC6, WC11 Grades T11 and T12; AS TM A335 grades P11 and P12.
- Can be utilized to splice and weld wear plate (i.e. AR400) to carbon or alloy steel. Requires controlled preheat and inter-pass temperatures as well as control of cooling rates
- These alloys are used extensively in the power generation and petrochemical industries.

TYPICAL CHEMISTRY (CO_2 GAS USED)

C	Mn	Si	P	S	Cr	Mo
.07	.81	.60	.010	.010	1.31	.45

TYPICAL MECHANICAL PROPERTIES

	After Stress relief for 1 hour @ 1175° F	
	100% CO_2	75%AR/25% CO_2
TENSILE STRENGTH	94,200 PSI	98,900 PSI
YIELD STRENGTH	84,200 PSI	85,200 PSI
%ELONGATION IN 2"	20%	22%

WELDING PARAMETERS

- Diameter .045"
- Shielding Gas CO_2 or Argon mixes up to 75% Argon.

FLAT		VERTICAL-UP		OVERHEAD	
VOLTS	AMPS	VOLTS	AMPS	VOLTS	AMPS
23-30	150-290	22-26	150-250	23-26	150-250

STANDARD PACKAGING

- 33 lb. spool

4/15/09

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