

## MIDALLOY MASTERCOR E81T1-B6M FLUX-CORED WIRE

### CLASSIFICATION

- AWS 5.29 Class E81T1-B6M / ASME SFA 5.29 Class E81T1-B6M

### DESCRIPTION

- MIDALLOY MASTERCOR E81T1-B6M 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 5 Cr ½ Moly alloys when elevated temperature service, corrosion resistance is required. Corrosion resistance is normally steam, hot hydrogen gas and high sulfur crude oils.
- Common materials include ASTM A336 Grade F5, ASTM A155 Grade 5 Cr, ASTM a 335 Grades P5 and P5B, ASTM A 199/A213 Grades T5 and T5B.
- These alloys are used extensively in the petrochemical and refinery industries.

### TYPICAL CHEMISTRY

C	Mn	Si	P	S	Cr	Mo
.08	.47	.27	.006	.010	4.85	.56

### TYPICAL MECHANICAL PROPERTIES

After Stress relief for 2 hours @ 1375° F 75% AR/ 25% CO<sub>2</sub>

TENSILE STRENGTH	89,000 PSI
YIELD STRENGTH	71,200 PSI
%ELONGATION IN 2”	19.9%
Impacts	60 ft. lbs. @ 70°F

### WELDING PARAMETERS

- Diameter .045”
- Shielding Gas 75% Ar/ 25% CO<sub>2</sub>

FLAT		VERTICAL-UP		OVERHEAD	
VOLTS	AMPS	VOLTS	AMPS	VOLTS	AMPS
21-32	130-300	21-29	130-260	21-30	150-280

### STANDARD PACKAGING

- 33 lb. spool

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