MIDALLOY MASTERCOR E81T1-B8 FLUX-CORED WIRE

CLASSIFICATION

- AWS 5.29 Class E81T1-B8 / ASME SFA 5.29 Class E81T1-B8

DESCRIPTION

- MIDALLOY MASTERCOR E81T1-B8 flux-cored wire is an all position flux-cored wire that is normally run in a flat, horizontal, and vertical up "shop position",

APPLICATIONS

- MIDALLOY MASTERCOR E81T1-B8 flux-cored wire is used for joining 9Cr-1Mo air hardening steels for elevated temperature creep service, and with corrosion resistance from steam, hot hydrogen gas, and high sulphur crude oils. These include steels such as A335 Grade P9, A336 Grade F9, A217 C12 (Cast), and A199, A200, and A213 Grade T9, used primarily in the petrochemical and refinery industries.
- A preheat and interpass temperature of not less than 400ºF should be maintained during welding.
- 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 COMPOSITION

C	Mn	Si	P	S
.09	.50	.35	.008	.010
Ni	**Cr**	**Mo**	**Cu**	**N**
.31	**9.30**	**1.05**	**.14**	**.020**

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	YIELD STRENGTH	ELONGATION IN
96,300 PSI	78,000 PSI	20%

RECOMMENDED WELDING PARAMETERS

DIAMETER	1/16"	.045"
SHEILDING GAS	25% CO_2 / 75% Ar @ 35 CFH	25% CO_2 / 75% Ar @ 35 CFH
AMPS & VOLTAGE SETTINGS-LOW V-UP	20V /160 AMPS	19V / 130 AMPS
MEDIUM	25V /220 AMPS	24V / 180 AMPS
HIGH	28V /270 AMPS	28V / 240 AMPS

- Electrode Stickout – ¾
- Contact tip – slightly below gas nozzle
- D C E P

STANDARD PACKAGING

- 33 lb. spool

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