

AUTOMIG FC 81T1-B2*

Classification
AWSA/SFA 5.29
E81T1-B2C

Flux Type
Rutile-Neutral

Characteristics

A folded flux-cored wire containing rutile flux, producing radiographic quality sound weld with good arc stability & easy slag detachability

Typical Applications

Best recommended for joining 1Cr - ½ Mo, ½ Cr - ½ Mo and similar composition creep resistant steels. Suitable for joining steels conforming to the specification: ● Grade F2 (P No. 3), F11 (all classes P No. 4), F12 (class 1&2P. No.4) of SA-182/ SA182M ● Grade T2 (P. No. 3), T11 & T12 (P. No.4) of SA-213/ SA-213M ● Grade WC6 of SA217/SA217M (P. No. 4) ● Grade P2 (P. No. 3), P11 & P12 (P.No.4) of SA-335/SA-335M ● Grade FP2 (P. No. 3), FP11 & FP12 (P. No. 4) of SA-369/ SA-369M ● Grade 2 (P. No.3), 11 & 12 (P. No. 4) of SA-387/ SA-387M ● Grade CP2 (P. No.3), CP 11 & CP12 (P. No. 4) of SA-426/SA-426M.

Shielding Gas: CO₂

10-15 liters/min

Current Condition: DC (+)

Weld Metal Chemistry, wt %

C	Mn	Si	Cr	Mo	S	P
0.05 - 0.12	1.25 max	0.25-0.55	1.00 -1.50	0.40 - 0.60	0.030 max	0.030 max

Diffusible H₂ content <5 ml/100gms of weld metal

All Weld Metal Mechanical Properties:

Condition	UTS	YS	% Elongation
	MPa	MPa	(L=4×d)
PWHT	550 -690	470 min	20 min

PWHT : 620° C/1hr

Chemical & mechanical properties given above are with A5.32 SG-C gas (100% CO₂)

The chemistry and mechanical properties of the weld will vary with the type of shielding gas

Welding Positions

F, H, V-up & OH

Packing Data

Dia., mm	1.2	1.6
Plastic Spools, net wt Kg	15	15

* Formerly known as - AUTOMIG FC 360



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