

Dual Shield II 80-Ni1

AWS A5.29 E81T1-Ni1C / JIS Z3313 T592T1-1CA-N2M1-U

Description

Flux
CORED
WIRES

- Dual Shield II 80Ni1 is an all-position wire which exhibits a smooth, easily controlled arc that produces a spray-like transfer. The slag firmly holds the molten puddle for out-of-position work and is easily removed. The alloying elements in the core are finely tuned to provide excellent low temperature impact toughness.

Shielding Gas : 100%CO₂

Application

- Dual Shield II 80Ni1 is used on petrochemical equipment, offshore oil construction, ship fabrication, and heavy machinery. The weld metal analysis is similar to an E8018-C3 low hydrogen covered electrode.

Typical Mechanical Properties of All Weld Metal

Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)	Impact Value J(kgf · m)
			-30°C
552 {56}	604 {62}	26	60 {6.1}

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S	Ni
0.048	1.16	0.40	0.015	0.004	1.04

Approvals

JIS