

# Dual Shield II 81-K2LH

AWS A5.29 E81T1-K2C / JIS Z3313 T556T1-1CA-N3

## Description

- Dual Shield II 81-K2LH is an all-position flux cored wire developed for low alloy high strength steels where low temperature impact toughness is required. The wire produces a smooth stable arc and low spatter levels similar to other Dual Shield II products.
- Dual Shield II 81-K2LH is a LMA flux cored wire with good CTOD (Max 5ml/gr)

## Shielding Gas : 100%CO<sub>2</sub>

## Application

- Applications include ship fabrication, offshore oil rigs, and heavy equipment construction.

## Typical Mechanical Properties of All Weld Metal

Yield Point N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Tensile Strength N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Elongation (%)	Impact Value J(kgf · m)		
			-30°C	-40°C	-60°C
530 {54}	605 {62}	29	131 {13.3}	100 {10.1}	65 {6.6}

## Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S	Ni
0.039	1.23	0.45	0.012	0.008	1.60

## Approvals

KR, ABS, LR, DNV, NK, BV, GL, JIS