

AK E81T1-Ni1M

Description: Rutile flux cored wire, containing 1%Ni, deposited metal with ultra-low diffusible hydrogen content; stable arc, less spatter, beautiful shape, good slag removal performance, excellent welding process performance; low temperature impact Excellent performance.

Application: Suitable for welding bridges, port machinery, shipbuilding, offshore platforms, LPG cryogenic equipment, etc. of the same strength level.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	—	—	—
Requirement	0.12	0.80	1.50	0.03	0.03	0.8-1.1	—	—	—
Actual Result	0.032	0.38	1.30	0.009	0.010	0.97	—	—	—

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	550-690	≥470	≥ 19	≥27J(-40℃)
Actual Result	590	530	25	106

Recommended welding parameters:

Diameter/ mm	1.0	1.2	1.6	
Welding voltage/V	15-20	22-32	25-38	—
Welding current/A	100-250	180-300	280-400	—