

AK E81T1-Ni1M

STANDARDS

GB/T 17493 E551T1-Ni1M
 AWS A5.20 E81T1-Ni1
 EN ISO 17632-A:T50 4 1Ni PM21

Ni-alloyed FCAW wire	FCAW	Low-temperature structural service
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PRODUCT OVERVIEW

<p>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.</p>	<p>Applications Suitable for welding bridges, port machinery, shipbuilding, offshore platforms, LPG cryogenic equipment, etc. of the same strength level.</p>
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TECHNICAL DATA

Typical Chemical Composition (%)

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

Typical Mechanical Properties

Item	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	550-690	≥470	≥19	≥27J(-40°C)
Actual	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	--

Note: Reorganized in English from the original product sheet for export presentation.