

ROFIL-81 B2

AN ALL POSITION LOW-ALLOY FLUX-CORED
WELDING WIRE FOR 1CR-0.50MO STEEL

BASIC ALLOY: FE, MN,CR, MO
AWS/SFA-5.29: E81T1-B2 1C/1M
EN ISO 17632-B T55ZT1-1CA-G

KEY FEATURES:

ROFIL-81 B2 an all position low alloy steel (1.25% Cr-0.5% Mo) flux cored wire especially designed to achieve the desired all-weld metal mechanical properties even in as-weld condition. These creep resistant steels are typically used in chemical industries for heat exchangers, boilers, piping and pressure vessels at service temperatures up to 1000°F.

APPLICATIONS

- Used to weld ½Cr-½Mo steels for elevated temperatures and corrosive service.
- The wire is suitable for high temperature and pressure service conditions in steam pipes, boilers, etc.

SHEILDING GAS

- Welding with CO2 gas and Ar+ CO2 gas mixture.

CHEMICAL COMPOSITION:

C	Mn	Si	S&P	Cr	Mo
0.05-0.12	1.25 Max.	0.80 Max.	0.030 Max	1.00-1.50	0.40-0.65

MECHANICAL PROPERTIES

YS (N/mm2)	UTS (N/mm2)	EL % (l=5d)
470 Min.	550-690	20Min.

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Spool packing 12.5 kg.	Spool packing 15kg
1.20	3/64"	120-300	18-22	✓	✓
1.40	1/18"	160-340	18-22	✓	✓
1.60	1/16"	180-360	18-22	✓	✓
2.00	5/64"	200-380	18-22	✓	✓