

ROFIL-81 Ni1

FLUX-CORED WELDING WIRE SUITABLE FOR LOW TEMPERATURES SERVICES

BASIC ALLOY: FE, MN, SI, NI
 AWS/SFA-5.29: E81T1-Ni1C/M-JH4
 EN ISO 17632-A: T 50 6 Ni1 P
 M1H5

KEY FEATURES:

ROFIL-81 Ni1 Designed for high strength, low-alloy applications using 75% Argon/25% CO₂. The use of mixed shielding gas stabilizes arc characteristics, reduces spatter levels, and washes out the weld bead for a flat appearance. Capable of producing weld deposits with impact toughness exceeding 80 J at -40°C

APPLICATIONS

- Suitable for offshore and similar applications

SHEILDING GAS

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

CHEMICAL COMPOSITION:

C	Mn	Si	S&P	Ni	Al	Cr	Mo
0.12 Max.	01.50 Max	0.80 max	0.030 Max	0.80-1.10	1.80 max	0.15 max	0.15 max

MECHANICAL PROPERTIES

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT	Diffusible Hydrogen MI/100g
470 Min.	550-690	19 Min.	- 40C : 80 J	4.00 ml max

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min.	Spool packing 12.5 kg.	Spool packing 15kg	Drum packing 100/200kg
1.20	3/ 64"	120-300	24-34	15-25	✓	✓	✓
1.40	1/ 18"	160-340	26-34	15-25	✓	✓	✓
1.60	1/ 16"	180-360	28-36	15-30	✓	✓	✓