# AK E81T1-Ni2M AWS A5.20 E81T1-Ni2M

## Low Alloy Steel Flux Cored Welding Wire

**E81T1-Ni2 is also designed for gas shielded flux cored welding of low alloy steels that require good CVN toughness at low temperatures. It is excellent for single-pass and multi-passes, all positional welding with good operation properties like easy slag removal, stable arc, less smoke and spatter etc.**

**1.2mm *15KG** **Lot No.：MN3059303** **Date：Aug.11.2024**

| AK E81T1-Ni2M | EN ISO 17632 | AWS A5.20 | Certificate number |
|---|---|---|---|
| Welding wire | A:T 46 6 2Ni PM1 1 | E81T1-Ni2M | 2408-1102 |

**CHEMICAL COMPOSITION OF WIRE（%）**

| | C | Si | Mn | S | P | Ni | Cr | Fe | Mo | Cu |
|---|---|---|---|---|---|---|---|---|---|---|
| % | 0.04 | 0.33 | 1.28 | 0.005 | 0.010 | 2.12 | —— | —— | —— | —— |

**THE TESTRESULTS OF MECHANICAL PROPERTY OF DEPOSITED METAL**

| Tension Test | | | Impact test | |
|---|---|---|---|---|
| Tensile Strength（Mpa） | Yield Point（Mpa） | Elongation（%） | Temp（0C） | Impact Value(J) |
| 618 | 530 | 26 | -40 | 103/104/102 |

| Bend test—Face | Bend test—Side | Redrying | X Reys Test | Dictonary flux | HRC | HD |
|---|---|---|---|---|---|---|
| —— | —— | —— | —— | —— | —— | —— |

**NOTICE: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.**

**CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJune Road, Miami, FL 33126: OSHA Safety and Health Standards 29 CRF 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.**