



MAXFIL-81R

Basic Type Flux Cored Wire



CODIFICATION: AWS/SFA 5.29 EN ISO 17632-B
E81T1-B2M T55ZT1-1MP-G

CHARACTERISTICS AND APPLICATIONS:

Maxfil-81R is an all position low alloy steel flux cored wire designed for welding of 1.25% Cr-0.5% Mo steel with high temperature and pressure service conditions in steam pipes and boilers. The slag coverage is complete and easy to remove. This wire burns with low spatter & minimal fumes with radiographic quality deposits.

Maxfil-81R is designed for single and multi-pass welding of similar composition steels and equivalent grade steels like; Gr. F2/F11/F12 of SA-182, Gr. T11 of SA-199, Gr. T2/T11/T12 of SA-213, Gr. WC6 of SA-217, Gr. P2/P11/P12 of SA-335, Gr. FP2/FP11/FP12 of SA-369, Gr. 2/11/12 of SA-387, Gr. CP2/CP11/CP12 of SA-426.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

| Element | C | Mn | Si | S | P | Cr | Mo |
|---------|-----------|------|------|-------|-------|-----------|-----------|
| Range | 0.05-0.12 | 1.25 | 0.80 | 0.030 | 0.030 | 1.00-1.50 | 0.40-0.65 |
| Typical | 0.062 | 0.80 | 0.40 | 0.012 | 0.017 | 1.25 | 0.52 |

MECHANICAL PROPERTIES OF ALL WELD METAL:

| Property | UTS (MPa) | YS (MPa) | % El (L=4d) |
|----------------|-----------|----------|-------------|
| Range | 550-690 | 470 Min | 19.0 Min |
| SR : 690°C/1Hr | 600 | 520 | 25.0 |

WELDING POSITIONS: H, F, VU, OH

WELDING PARAMETER: DC (+)

| Diameter (mm) | HORIZONTAL/FLAT | | VERTICAL UP | | OVERHEAD | |
|---------------|-----------------|------------|-------------|------------|----------|------------|
| | Volt, V | Current, A | Volt, V | Current, A | Volt, V | Current, A |
| 1.20 | 26-32 | 160-260 | 22-26 | 100-160 | 24-28 | 100-160 |
| 1.60 | 26-32 | 180-300 | 22-26 | 110-200 | 24-28 | 110-200 |

APPROVALS:

CE MARKING

SHIELDING GAS:

➤ Argon - Carbon Dioxide CO₂ (80:20%) at flow rate 12-15 litres per minute.

PACKING:

Standard size : 1.20 & 1.60mm. Other diameters may be available on request.

Quantity : Supplied approximately 15Kgs in a plastic spool. Each spool is sealed in an air tight polythene bag and then packed in a corrugated box.

An ISO 9001: 2015 Certified Company

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