

TM81 I-B2



TM81 I-B2 deposits a weld metal containing 1,25% Cr and 0,5% Mo and is designed for welding creep resistant steels for service up to 550°C. TM81 I-B2 offers good weldability in all positions, with a fast freezing slag that removes easily. The wire is recommended for single and multi pass welding in all positions using either 100% CO₂ or 75/25 Ar/CO₂ shielding gases.

CLASSIFICATION

AWS A5.29 E81 T1-B2-H4

CHEMICAL ANALYSIS (TYPICAL)

% Carbon	0.05	% Phosphorous	0.004
% Manganese	0.57	% Molybdenum	0.46
% Silicon	0.39	% Chromium	1.22
% Sulphur	0.005		

**TYPICAL MECHANICAL PROPERTIES
(ALL WELD METAL IN THE AS
WELDED CONDITION)**

	100% CO ₂	75% Ar/25% CO ₂
Yield Strength	591 MPa	763 MPa
Tensile Strength	682 MPa	687 MPa
Elongation on 5d	20%	19%
Charpy V-Notch	N/R	N/R

PACKING DATA

DC+

Diameter (mm)	Volts	Amps	Deposition Rate Kg/Hr	Item Number	Pack Mass (Kg)
1.2 Flat & Horizontal	24	175	2.3	081-144	15 Kg Spool
	28	250	4.2		
	30	300	5.8		
1.2 Vertical & Overhead	24	175	2.3		
	26	200	2.9		
	27	225	3.4		
1.6 Flat & Horizontal	28	300	4.2	081-145	15 Kg Spool
	29	350	5.7		
	33	400	7.1		
1.6 Vertical & Overhead	24	200	4.2		
	25	225	2.8		
	26	250	3.2		

Bold indicates optimum parameters for welder appeal.

Recommended shielding gas: 100% CO₂ or Afrox Fluxshield.

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