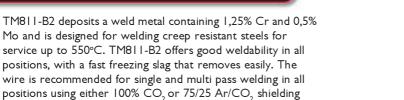
PRODUCT DATA SHEET

TM811-B2





CLASSIFICATION

AWS A5.29 E81T1-B2-H4

CHEMICAL ANALYSIS (TYPICAL)

% Carbon	0.05	
% Manganese	0.57	
% Silicon	0.39	
% Sulphur	0.005	

% Phosphorous	0.004
% Molybdenum	0.46
% Chromium	1.22

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)
	24	175	2.3		
1.2	28	250	4.2		
Flat & Horizontal	30	300	5.8		
	24	175	2.3	081-144	15 Kg Spool
1.2	26	200	2.9		
Vertical & Overhead	27	225	3.4		
	28	300	4.2		
1.6	29	350	5.7		
Flat & Horizontal	33	400	7.1	081-145	15 Kg Spool
	24	200	4.2		
1.6	25	225	2.8		
Vertical & Overhead	26	250	3.2		

Bold indicates optimum parameters for welder appeal.

Recommended shielding gas: 100% CO2 or Afrox Fluxshield.

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For more information contact the Afrox Customer Service Centre, tel: 0860 020202 or e-mail: customer.service@afrox.boc.com Website: www.afrox.com

