

K-81T

AWS E81T1-Ni1
JIS YFW-C602R
KS YFW-C602R

FOR HIGH TENSILE
STRENGTH STEEL

Typical applications

K-81T is designed for welding of 590MPa high tensile steel with slow freezing slag system. Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications.

Characteristics on Usage

- ① Wire is a titania type of flux cored wire for all-position welding.
- ② It provides good wet-in capabilities along with high impact values at low temperatures.
- ③ It allows you to weld over rust, mill scale and some primers without the need for pre-cleaning.
- ④ It also provides smooth arc, low spatter levels, beautiful bead appearance.
- ⑤ The shielding gas should be used 100%CO₂ for welding.
- ⑥ Refer to page 150 for more information on usage.

Typical chemical composition of all-weld-metal (%)

Shielding Gas	C	Si	Mn	Ni	Mo
CO ₂	0.04	0.35	1.17	0.92	0.2

Typical mechanical properties of all-weld-metal

Shielding Gas	Y · P	T · S	EI	Charpy V-notch
	N/mm ² {kgf/mm ² }	N/mm ² {kgf/mm ² }	(%)	J {kgf · m} (-30°C)
CO ₂	590 {60}	650 {66}	28	120 {13}

Sizes available and recommended currents (DC wire[⊕])

Dia.	(mm)	1.2	1.6
Amp.	F		
	H-Fil	120~320	200~450
	V	120~220	180~230

Package

Dia.	(mm)	1.2	1.4	1.6
Spool	(kg)		5, 12.5, 15, 20	
Pailpack	(kg)		100~300	

Welding positions



Approved by

ABS, BV, DNV, GL, KR, LR, NK