

Need Metal? We get it!

SpecMet CSF-81B2(L)

AWS A5.29 E81T1-B2(L)C - A5.36 E81T1-C1PZ-B2(L)
 KS D 7121 YF1CM-C
 JIS Z 3318 T55T1-1C-1CM
 EN ISO 17634-A T CrMo1 P C 1 - ISO 17634-B T55T1-1C-1CM

Applications

Welding of 1.25%Cr-0.5%Mo Steel used for fire power plant and high pressure boiler, pressure vessel, chemical and oil refining industries etc.

Characteristics

- (1) CSF-81B2(L) is a titania type flux cored wire and designed for all-position welding with CO₂ gas Shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- (3) It is suitable in welding of low alloy steel of Cr-Mo or carbon steel, high strength steel.

Notes on Usage

1. Need preheating and interpass temperature control for cold cracking prevention
2. Weld by low heat input to secure good mechanical properties and crack resistance of weld zone

Typical Chemical Composition of Weld Metal (%) (shielding gas: 100% CO₂)

	C	Mn	Si	P	S	Cr	Mo
B2	0.06	0.62	0.58	0.018	0.013	1.27	0.51
B2L	0.03	.064	0.56	0.014	0.012	1.24	0.50

Typical Mechanical Properties of Weld Metal (%) (shielding gas: 100% CO₂)

	YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL (%)	Heat Treatment
B2L	661	727	21.0	As welded
B2L	562	622	25.0	690°C x 1 Hr SR

Size and Recommended Current Range (DC+)

Dia (mm)		1.2	1.6
Amp	F & HF	180-340	200-400
Amp	V-Up	120-220	160-260
Amp	V-Down	160-300	200-320
Amp	OH	120-220	160-260