

CSF-81T

For 550N/mm² class high tensile strength steel

AWS	A5.29	E81T1-Ni1C
KS	D 7104	YFW-C55DR
JIS	Z3313	T553T1-1CA-N2-H10

Applications

Butt, fillet welding of 550N/mm² high tensile strength steels of structure such as ships, bridges, buildings and storage tanks etc.

Characteristics

- (1) CSF-81T is a titania type flux cored wire and designed for all-position welding by single pass & multi pass 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 provides a good welding efficiency thank to high deposition rate particularly.

Notes on usage

- (1) The optimum flow of CO₂ for shielding is 20~25ℓ/min.
- (2) The distance between tip & base metal is to be 15~25mm.
- (3) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (4) Thick heavy plate should be welded under proper preheating & interpass temperature.

Typical chemical composition of weld metal (%)

(Shielding gas : 100%CO₂)

C	Mn	Si	P	S	Ni
0.05	1.30	0.40	0.011	0.011	0.95

Typical mechanical properties of weld metal

(Shielding gas : 100%CO₂)

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV (J)	
			-20℃	-30℃
568	620	28.0	125	100

Size & recommended current range (DC +)

Dia. mm (in)		1.2 (0.045)	1.4 (0.052)	1.6 (0.062)
Amp.	F & H-F	180~340	200~360	200~400
	V-up	120~220	140~260	160~260
	V-down	120~240	140~260	160~280
	OH	120~220	140~260	160~260

• Approval : ABS