

SC-81B2

TYPE : Rutile

AWS A5.29/ ASME SFA5.29 E81T1-B2C
EN ISO 17634-A-T CrMo1 P C 2

Applications

SC-81B2 can be used for welding of 1.25%Cr-0.5%Mo heat resistant steels used for steam pipes of boilers for electric power plants and marine use, equipment for oil refining industries and high temperature synthetic chemical industries.

Most common usage is in steam power plants and ships, chemical plants and refineries.

Characteristics on Usage

SC-81B2 is a titania type flux cored wire for all position welding. Arc stability is excellent. Spatter loss is low and slag covering is uniform with good removability.

Notes on Usage

- ① Use 100% CO₂ gas.
- ② All position gas shielded flux cored wire.

Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

DC +

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.066	0.41	0.83	0.016	0.017	1.19	0.51

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	PWHT
575 (83,500)	656 (95,200)	22.4	690±15° C×1Hr

Approval

I Packing

Dia. (mm)	1.2	1.4	1.6	Spool(kg)	15
(in)	.045	.052	1/16	(lbs)	33

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	250~300	280~350	300~450
V-up & OH	200~260	220~260	240~280
V-Down	250~300	280~350	300~450