

KFX-81TN

Shielding Gas: 100% CO₂

Classification

AWS A5.29/A5.29M	E81T1-Ni1C/E551T1-Ni1C
JIS Z3313	T553T1-1CA-N2
EN ISO 17632-A	T46 3 1Ni P C1 1 H5
GB T17493	E551T1-Ni1C

Applications and Features

- (1) KFX-81TN is suitable for welding 550N/mm² grade steel.
- (2) Excellent toughness due to 1% Ni.
- (3) Ideal for welding pressure vessel, steel structure, offshore structure, tank and pipeline.

Welding position



Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Ni
0.03	0.30	1.33	0.018	0.006	0.90

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
623	584	28	-30	160
			-40	121

Size and Suggested Operating Range (DC+)

Diameter (mm)	1.2	1.4	1.6
F/HF	140~300A/23~36V	150~350A/22~34V	200~450A/28~42V
H	140~280A/22~33V	150~280A/22~32V	220~280A/23~29V
V-up/OH	140~220A/22~28V	150~230A/22~28V	160~280A/22~28V
V-down	230~280A/28~33V	250~300A/28~32V	250~320A/28~32V