

TWE-811B2

AWS A5.29 E81T1-B2C

Characteristics and Applications:

TWE-811B2 is a gas-shielded and all-position flux-cored wire intended for 1~1.25%Cr-0.5%Mo low alloy steel welding. It is used with 100%CO₂ shielding gas and offers good operator appeal. TWE-811B2 is ideal for welding Cr-Mo steel pipe and Cr-Mo steel, which need high creep resistance.

Notes on usage:

1. Pre-heat at 150-300°C, and PWHT at 690°Cx1hr.
2. Keep the product dry, while it is stored or delivered.
3. Use 99.8% or higher purity of CO₂ Gas.
4. Use DC(+) polarity.

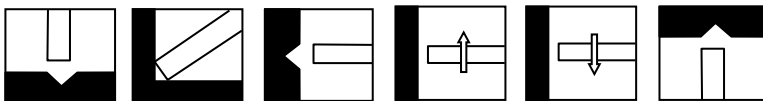
Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Cr	Mo
0.06	0.60	0.28	0.014	0.008	1.12	0.55

Typical mechanical properties of weld metal:

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	PWHT
560(81)	640(93)	23	690°Cx1hr

Welding position:



Sizes and recommended parameter range (DC +):

Stick out:15-25(mm), gas flow rate:20-25(l/min):

Diameter(mm)		1.2	1.6
Position	F HF	180A-300A/26V-36V	180A-350A/26V-38V
	VU OH	150A-220A/24V-28V	160A-230A/24V-28V

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