

Classifications

EN ISO 17632-A	EN ISO 17632-B	AWS A5.29 / SFA-5.29
T46 3 Z2Ni Y NO 1 H10	T55 3 T8-1 NO A-GN5-U H10	E81T8-G

Characteristics and typical fields of application

Böhler Pipeshield 81 T8-FD is a self-shielded flux-cored wire and is especially developed for semi-automatic vertical down welding of pipelines. It is also suitable for welding of low alloyed steel constructions. This wire offers a fast freezing, easy removable slag and excellent welding characteristics in all positions. Böhler Pipeshield 81 T8-FD is designed to offer both good mechanical properties and high impact toughness at low temperatures. The outstanding benefits are especially accessible in the vertical down position for (hot pass) filler and cap layers. Due to the fluoride-basic filling the interpass temperature can be arranged similar to that of basic electrodes, we recommend 80 – 200°C.

Böhler self-shielded flux-cored wire provide an easy handling for the welder due to a very tolerant stick out length and loss tendency to porosity also when welding with a longer arc length as a result of higher voltage.

Base materials

Acc. to API 5L: X65, X70

Typical analysis

	C	Si	Mn	Ni	Al
wt.-%	0.04	0.25	1.6	2.25	0.9

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R_e	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J		
	MPa	MPa	%	+20°C	-30°C	-40°C
u	520 (≥ 470)	620 (550 – 690)	27 (≥ 20)	200	140 (≥ 47)	120

u untreated, as welded- without shielding gas

Operating data

	Polarity	DC –	Dimension mm
	Shielding gas (EN ISO 14175)	NO GAS	2.0

Recommended stick out: 10 – 25 mm

Approvals

-