

Applications

All position welding of building, shipbuilding, bridge construction machinery, and vehicles.

Characteristics on Usage

- ① SL-81LT is a titania type Seamless flux cored wire for all position welding.
- ② It provides excellent notch toughness at low temperature.
- ③ It provides an exceptionally smooth and stable arc with a fast freezing slag system.

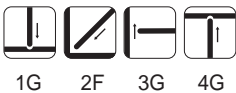
Notes on Usage

- ① Proper Preheating(50~150°C)(122~302°F) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ② One-side welding defects such as hot cracking may occur with wrong welding parameter such as high welding speed.
- ③ Use 100%CO<sub>2</sub> gas.

Welding Position(All-Position)

Current

Shielding Gas



Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.04	0.30	1.35	0.009	0.009	1.62

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
570 (82,800)	615 (89,300)	21	-40 (-40)	80 (59)
			-60 (-76)	40 (30)

Approval I Packing(Including Ball Pac)

Dia. (mm)	1.2	1.4	Spool(kg)	12.5
(in)			(lbs)	

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2	1.4
F	250~300	270~330
V-up,OH	170~230	180~240
V-down	250~300	170~320