

Applications

TOKO E81T1-K2C is used for the welding of low temperature service steels in the construction of LPG and LNG storage tanks.

Characteristics on Usage

TOKO E81T1-K2C is a titania type flux cored wire designed for all position welding with CO₂ shielding gas.

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% CO₂ gas.

Welding Position	Current	Shielding Gas
 1G (PA) 2F (PB) 3G (PF) 4G (PE)	DC +	CO ₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.04	0.35	1.35	0.012	0.011	1.50

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
540 (78,400)	620 (90,000)	28	-30 (-22) -60 (-76)	110 (81) 60 (44)

Approval	Packing
BV, DNV, GL, LR, NK, CCS,	Dia. (mm) 1.2 1.4 1.6 (in) 0.045 0.052 1/16
	Spool(kg) 15 (lbs) 33

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.6 (1/16)
F & HF	250~300	300~350
V-up, OH	170~230	200~250
V-down	250~300	300~350