

Supercored 81MAG

FLUX CORED ARC WELDING CONSUMABLE
FOR WELDING OF LOW-TEMPERATURE
SERVICE STEEL



Supercored 81MAG

❖ Specification

AWS A5.36

E81T1-M21A8-Ni1 H4

E81T1-M21P5-Ni1 H4

(AWS A5.29

E81T1-Ni1M H4)

EN ISO 17632-A

T 46 6 1Ni P M21 2 H5

❖ Applications

Supercored 81MAG meet NACE requirements. It can be used for oil and gas construction, pipe, and offshore stations.

❖ Characteristics on Usage

Supercored 81MAG is a titania-type flux cored wire to be used with Ar+CO₂ gas mixture shielding. It provide excellent notch toughness at low temperature ,not only as-welded but also stress relieved state.

❖ Note on Usage

1. Proper preheating(50~150 °C (150~302 °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. Use Ar+20~25% CO₂ gas.

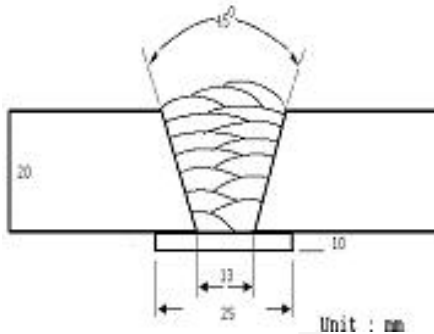


Supercored 81MAG

Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions

Method by AWS Spec.



[Joint Preparation & Layer Details]

Diameter(mm)	: 1.2mm(0.045in)
Shielding Gas	: Ar+20%CO ₂
Welding Position	: 1G
Amp./ Volt.	: 270~280 /29~30
Stick-Out(mm)	: 20~25 (0.79~0.98in)
Pre-Heat(°C)	: R.T.
Interpass Temp.(°C)	: 150±15 (302±59 °F)

❖ Mechanical Properties of all weld metal

Consumable	Tensile Test			CVN Impact Test J(ft·lbs)		Remark
	YS MPa(ksi)	TS MPa(ksi)	EL(%)	-40°C (-40°F)	-60°C (-76°F)	
Supercored 81MAG	550(80)	590(86)	26.0	110(81)	60(44)	As welded
AWS A5.36 E81T1-M21A8-Ni1 H4	≥ 470(68)	550~690 (80~100)	≥ 19	≥ 27(20) at -60°C (-76°F)		-
Supercored 81MAG	510(74)	570(83)	28.0	98(72)	35(26)	PWHT (620°C ×2hr)
AWS A5.36 E81T1-M21P5-Ni1 H4	≥ 470(68)	550~690 (80~100)	≥ 19	≥ 27(20) at -45°C (-49°F)		-

❖ Chemical Analysis of all weld metal(wt%)

Consumable	C	Si	Mn	P	S	Ni
Supercored 81MAG	0.05	0.28	1.20	0.008	0.012	0.93
AWS A5.36 E81T1-M21A8-Ni1 H4	≤ 0.12	≤ 0.80	≤ 1.50	≤ 0.03	≤ 0.03	0.8~1.1

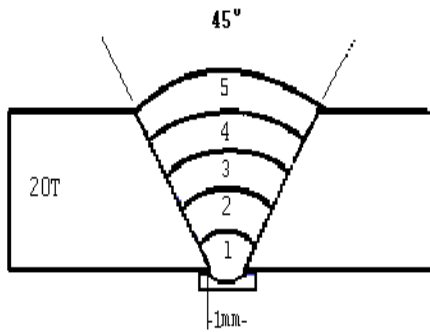
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Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions

Method by AWS Spec.



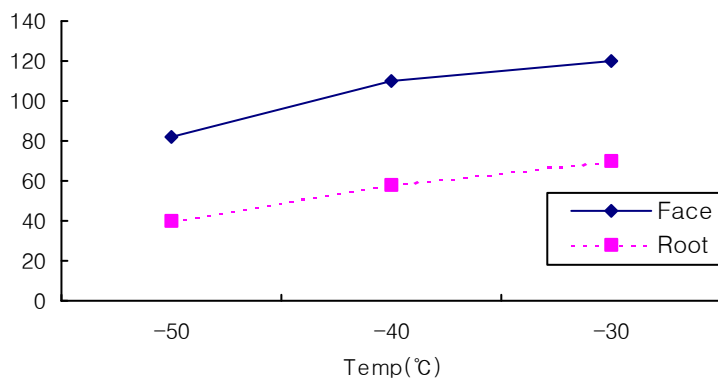
[Joint Preparation & Layer Details]

Diameter(mm)	: 1.2mm(0.045in)
Shielding Gas	: Ar+20% CO ₂
Welding Position	: 3G (v-up)
Amp./ Volt.	: 1 pass : 180 /25 2pass~: 210~220/25~26
Stick-Out(mm)	: 20~25
Pre-Heat(°C)	: R.T .
Interpass Temp.(°C)	: 150±15 (302±59 °F)
Polarity	: DC(+)

❖ Mechanical Properties of all weld metal

		CVN Impact Test J(ft·lbs)	
		-50 °C (-58 °F)	-40 °C (-40 °F)
Location of specimen	Face	80(59)	100(74)
	Root	40(30)	60(44)

Charpy v-notch test



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Welding Efficiency

❖ Deposition Rate & Efficiency

Wire Size	Welding Conditions		Wire Feed Speed m/min (in/min)	Deposition Efficiency(%)	Deposition Rate kg/hr(lb/hr)
	Amp.(A)	Volt.(V)			
1.2mm (0.045in)	200	26	10.2(400)	84~86	3.2(7.0)
	250	28	13.3(525)	85~87	4.4(9.7)
	300	32	15.3(600)	86~88	5.5(12.1)
Remark				Deposition efficiency =(Deposited metal weight/ Wire weight used)×100	Deposition rate =(Deposited metal weight/ Welding time,min.)×60

* Shielding Gas : Ar+20%CO₂



Diffusible Hydrogen Content

❖ Welding Conditions

Diameter(mm)	: 1.2mm(0.045in)	Amps(A) / Volts(V)	: 270 / 29
Shielding Gas	: Ar+20%CO ₂	Stick-Out(mm)	: 20mm(0.79in)
Flow Rate(ℓ /min.)	: 20	Welding Speed	: 35 cm/min (13.8 in/min)
Welding Position	: 1G	Current Type & Polarity	: DC(+)

❖ Hydrogen Analysis Using Gas Chromatography Method

Hydrogen Evolution Time	: 72 hrs
Evolution Temp.	: 45 °C(113°F)
Barometric Pressure	: 780 mm-Hg

❖ Result(ml/100g Weld Metal)

X1	X2	X3	X4
3.4	3.5	3.3	3.4

Average Hydrogen Content 3.4 ml / 100g Weld Metal



Supercored 81MAG

❖ Proper Current Range

Consumable	Shielding Gas	Welding Position	Wire Dia.
			1.2mm(0.045in)
Supercored 81MAG 1.2mm (0.045in)	Ar+20%CO ₂	Flat	180~300 Amp
		V-up Over head	170~240 Amp
		V-down	180~300 Amp

❖ AUTHORIZED APPROVAL DETAILS

Consumable	Max. dia(mm)	Welding position	Register of shipping & Size(mm)			
			ABS	LR	BV	DNV
Supercored 81MAG	1.2	All V-down	5Y400SA H5 1.2 (0.045in)	5Y40S H5 1.2 (0.045in)	SA5Y40M HHH 1.2 (0.045in)	VY40MS H5 1.2 (0.045in)

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