

CORMET™ 5

Low Alloy, All Position ▪ AWS E81T1-B6C/M

KEY FEATURES

- Designed for high strength and improved corrosion resistance with hot hydrogen gas, super-heated steam, and Sulphur crude oils
- Smooth arc performance in all positions

WELDING POSITIONS

All

SHIELDING GAS

80% Argon / 20% CO₂
Flow Rate: 40-50 CFH

CONFORMANCES

AWS 5.29 E81T1-B6C/M

TYPICAL APPLICATIONS

- Piping
- Steam Generating Power Plant
- Pressure Vessels
- Oil Refineries

DIAMETERS / PACKAGING

Diameter mm (in)	15 kg (33.1 lb) Spool
1.2 (0.045)	CM5-12

MECHANICAL PROPERTIES⁽¹⁾

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %
Requirements AWS E81T1-B6C/M	470 (68)min	550 (80) min	19 min
Typical Performance⁽³⁾ As-Welded	600	690	22

DEPOSIT COMPOSITION⁽¹⁾

	%C	%Mn	%Si	%S	%P
Requirements AWS E81T1-B6C/M	0.05-0.10	1.20 max	0.50 max	0.030 max	0.030 max
Typical Performance⁽³⁾	0.06	0.8	0.3	0.01	0.01
	%Cr	%Ni	%Mo	%Cu	
Requirements AWS E81T1-B6C/M	4.0-6.0	0.40 max	0.45-0.65	0.3 max	
Typical Performance⁽³⁾	5	0.01	0.5	0.05	

TYPICAL OPERATING PROCEDURES

Diameter mm (in)	Polarity	Amp-Volt Range	Typical	Stickout mm (in)
1.2 (0.045)	DC+	160-260A / 24-30V	25V	15-25 (5/8-1)

⁽¹⁾ Typical all weld metal ⁽²⁾ Measured with 0.2% offset ⁽³⁾ See test results disclaimer ⁽⁴⁾ Preferred polarity is listed first

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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