

Primacore® MW-81Ni1H

Key Features

- An all position gas shielded 1% Nickel, micro alloyed flux-cored welding wire.
- Excellent mechanical properties.
- Excellent low temperature impact properties.
- Very good weldability, low spatter and good bead appearance.
- Vacuum packed poly foil bags.

Typical Applications

- Designed specially for applications where excellent low temperature impact properties are required.
- Designed for offshore drilling rig construction, weathering steels, petrochemical and similar applications.

Welding Positions



Conformances

AWSA5.29: E81T1-Ni1M-JH4

AS/NZS ISO 17632-B: T 55 4 T1-1 M A N2 H5

Shielding Gas

- 75-85% Argon, 15-25% CO₂
- Flow Rate: 15-25 L/min

Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts	Current amps	CTWD mm
1.2	COP81MHE21	Spool 15kg VFB	175-600	20-32	130-310	15-20
1.6	COP81MHE61	Spool 15kg VFB	130-300	21-30	180-350	20-25

Mechanical Properties - As required per AWS A5.29

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -40°C
Requirements AWS A5.29 E81T1-Ni1M-JH4	470 min	550-690	19 min	27 min
Typical Values (with 80%Ar/20%CO ₂)	505	570	28	132

Deposit Composition

	%C	%Mn	%Si	%P	%S	%Ni
Typical Results	0.06	1.10	0.29	0.007	0.006	0.93
	%Cr	%Mo	%V	Diffusible Hydrogen		
Typical Results	0.04	0.004	0.02	3.5 ml / 100 g		