

FICHA TÉCNICA

PRIMACORE™ LW-81Ni1



FLUX CORED WIRE



PRIMACORE™ LW-81Ni1 is an all position gas shielded 1% Nickel, micro alloyed flux-cored welding wire. It is designed specifically for applications where exceptional low temperature impact properties are required.

CONFORMANCE

JIS Z 3313: T554T1-1CA-N2-H10
ANSI/AWS A5.29 / ASME SFA-5.29: E81T1-Ni1J-C

APPROVALS

GL: 4Y40H10
LR: 4Y40SH10
BV: SA4YMH10
NK: KSW54Y40G(C)H10
CCS: 4Y40SH10
ABS: 4Y400SA(H10)
DNV: IVY40MS(H10)
RMRS: 4Y40MSH10

SHIELDING GAS

100% CO₂ shielding gas.
Flowrate: 40-45 CFH or 20 litres/min

DIAMETERS / PACKAGING

Diameter (mm)	Spool/Drum Weight (kg)	Pallet Weight (kg)	Product No.
1.2	15	1,080	COPLW81E21
1.4	15	1,080	COPLW81E41
1.6	15	1,080	COPLW81E61
1.2	225	900	COPLW81E28
1.4	200	800	COPLW81E48
1.6	200	800	COPLW81E68

Cone + Conduit Adapter
Part No.: QTM-00003

WELDING POSITIONS



DIFFUSIBLE HYDROGEN

Diffusible hydrogen conforms to relevant agency approval designations.

ADVANTAGE LINCOLN

- Exceptional mechanical properties.
- Superior low temperature impact properties and CTOD values.
- Outstanding weldability, low spatter and good bead appearance.
- Suitable for replacing E8018-C3 stick electrode and for welding A588 weathering steel where colour match is required.
- Designed for offshore drilling rig construction, weathering steels, petrochemical and similar applications.
- Manufactured under a quality system certified to ISO 9001 and JIS requirements.

PACKAGING TYPE

- All spools of wire are level layer wound on plastic spools.
- The spools are then vacuum-packed in moisture proof, polyfoil bags.
- The spools of wire are boxed and securely stacked on wooden pallets with plastic shrink-wrap.

LINCOLN
ELECTRIC
THE WELDING EXPERTS™

FICHA TÉCNICA

PRIMACORE™ LW-81Ni1



MECHANICAL PROPERTIES - ALL WELD METAL

	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Reduction of Area (%)	Charpy V-Notch (J) @-29°C @-40°C	
Requirements AWS A5.29: E81T1-NiJ-C	470min	550-690	19min.	-	27 min. ⁽¹⁾	27 min. ⁽²⁾
Test Results* (with 100% CO ₂)	527	592	28	75	167 avergae (163, 171, 168)	152 avergae (146, 152, 159)

*1.2mm diameter wire,DC+. Typical all weld metal in the as welded condition. (1) For E81T1-Ni1 only. (2) For E81T1-Ni1J only.

*Test results and product properties listed herein for gas shielded wires have been developed with the shielding gas stated.

A change of shielding gas may cause significant changes in product performance and weld metal properties.

Lincoln Electric does not warrant these products for use with shielding gases other than those listed in the test data.

CHEMICAL COMPOSITION - ALL WELD METAL

	C	Mn	Si	S	P	Ni	Cr	Mo	V
Requirements AWS A5.29 E81T1-NiJ-C Max.	0.12	1.50	0.80	0.03	0.03	0.80	0.15	0.35	0.05
Test results* (with 100%CO ₂)	0.03	1.31	0.35	<0.01	0.01	0.85	0.03	<0.01	0.02

CTOD TEST RESULTS (per ASTM E1290)

TEST temperature	CTOD Values (mm)	CTOD Average (mm)
-10°C	0.399, 0.544, 0.372	0.438
-20°C	0.279, 0.198, 0.474	0.317

TYPICAL OPERATING PROCEDURES

Diameter Polarity CTWD mm (inches)	Wire Feed Speed in/min (cm/min)	Voltage (Volts)	Approx.Current (Amps)	Melt-Off Rate (Kg/hr)	Deposition Rate (Kg/hr)
1.2mm PRIMACORE™ LW-81Ni1 DC+ 20(3/4)	175 (445)	21-24	130	1.8	1.5
	225 (572)	23-25	165	2.4	1.9
	275 (699)	25-27	185	2.9	2.4
	325 (826)	26-29	200	3.4	2.9
	375 (953)	27-29	230	4.0	3.3
	425 (1,080)	28-30	250	4.5	3.7
	475 (1,207)	29-31	270	5.0	4.2
	600 (1,524)	31-33	310	6.2	5.3
1.4mm PRIMACORE™ LW-81Ni1 DC+ 25(63/64)	150 (381)	23-25	150	2.0	1.7
	200 (508)	24-26	190	2.6	2.2
	250 (635)	25-27	225	3.3	2.8
	300 (762)	26-28	240	4.0	3.6
	350 (889)	27-29	275	4.6	3.7
	400 (1,016)	28-30	300	5.3	4.5
	450 (1,143)	29-31	325	6.0	5.1
1.6mm PRIMACORE™ LW-81Ni1 DC+ 25(63/64)	130 (330)	22-25	180	2.6	2.2
	150 (381)	23-26	210	3.0	2.5
	200 (508)	24-27	265	3.9	3.2
	250 (635)	26-29	305	4.9	4.1
	300 (762)	28-31	345	5.8	4.9