



Chandraprabhu Enterprise Private Limited

LOW ALLOY WELDING WIRES

Name: CEPL-104 AWS A 5.29 E81 T1-Ni2

Weld metal chemistry (with CO2 shield)	C = 0.10% Max, Mn = 0.90 to 1.50%, P = 0.03% Max, Si = 0.55% Max, S = 0.03% Max, Ni = 1.75–2.50%		
Typical all weld mechanical properties (with CO2 shield)	UTS = 590N/mm2 Min; YS = 510N/mm2 Min; Elongation(%) = 20 min. Typical charpyVnotch Impact value at –40°C = 40 J Min		
Welding parameter guidelines (with CO2 shield)	Size	Range	Recommended
	1.20mm	90–300A, 18–28V	180–300A, 22–26V(F), 100–150A, 18–22V(P)
	1.60mm	125–400A, 18–30V	220–350A, 25–30V(F), 125–200A, 18–22V(P)

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