



Chandraprabhu Enterprise Private Limited

LOW ALLOY WELDING WIRES

Name: CEPL-105 AWS E E81 T1-A1C

Weld metal chemistry (with CO2 shield)	C = 0.10% max, Mo = 0.45-0.55%, Mn = 0.80-1.10%, S & P = 0.03% max, Si = 0.60%max		
Typical all weld mechanical properties (with CO2 shield)	UTS = 590N/mm ² ; YS = 510N/mm ² ; Elongation(%) = 20 min Typical charpyVnotch Impact value at -30°C = 40 Joules		
Welding parameter guidelines (with CO2 shield)	Size	Range	Recommended
	1.20mm	90-300A, 18-30V	180-300A, 22-26V(F), 100-150A, 18-22V(P)
	1.60mm	125-400A, 18-32V	220-350A, 25-30V(F), 125-200A, 18-22V(P)

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