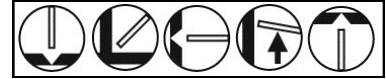


TM-811N1



AWS A5.29: E81T1-Ni1CJ H4, E81T1-Ni1MJ H4

WELDING POSITIONS:



FEATURES:

- Fast-freezing slag
- Nominal 1% nickel deposit
- Excellent impact toughness
- Low-hydrogen deposit
- Low spatter and excellent slag removal

BENEFITS:

- Excellent out-of-position performance
- Suitable to replacement to E8018-C3 stick (SMAW) electrodes
- Resists cracking in severe applications
- Assists in minimizing the risk of hydrogen-induced cracking
- Improves operator appeal, reduces clean-up time

APPLICATIONS:

- High-strength low-alloy steels
- Single and multi-pass welding
- Weathering steels (ASTM A588, A709, etc.)
- Bridge fabrication
- Heavy equipment fabrication
- Structural fabrication
- Shipbuilding

SLAG SYSTEM OR WIRE TYPE: Fast-freezing, rutile-type, flux-cored wire

SHIELDING GAS: 100% Carbon Dioxide (CO₂), 75-80% Argon (Ar)/Balance Carbon Dioxide (CO₂), 35-50 cfh (16-24 l/min)

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP)

STANDARD DIAMETERS: 0.045" (1.2 mm), 0.052" (1.4 mm), 1/16" (1.6 mm)

RE-DRYING: Not recommended

STORAGE: Product should be stored in a dry, enclosed environment, and in its original intact packaging

TYPICAL WELD METAL CHEMISTRY* (Chem Pad):

Weld Metal Analysis %	100% CO ₂	75% Ar/25% CO ₂	AWS Spec
Carbon (C)	0.03	0.06	0.12
Manganese (Mn)	1.09	1.39	1.50
Phosphorus (P)	0.007	0.009	0.030
Sulphur (S)	0.005	0.008	0.030
Silicon (Si)	0.32	0.53	0.80
Nickel (Ni)	1.01	1.00	0.80-1.10

Note: AWS specification single values are maximums.

TYPICAL DIFFUSIBLE HYDROGEN*:

Hydrogen Equipment	100% CO ₂	75% Ar/25% CO ₂	AWS Spec
(GAS CHROMATOGRAPHY)	2.4 ml/100g	3.0 ml/100g	4.0 ml/100g Maximum

TYPICAL MECHANICAL PROPERTIES* (As Welded):

Mechanical Tests	100% CO ₂	75% Ar/25% CO ₂	AWS Spec
Tensile Strength	83,000 psi (572 MPa)	93,000 psi (641 MPa)	80,000-100,000 psi (550-690 MPa)
Yield Strength	73,000 psi (503 MPa)	85,000 psi (586 MPa)	68,000 psi (470 MPa) Minimum
Elongation % in 2" (50 mm)	26%	25%	19% Minimum

TYPICAL CHARPY V-NOTCH IMPACT VALUES* (As Welded):

CVN Temperatures	100% CO ₂	75% Ar/25% CO ₂	AWS Spec
CVN @-40°F (-40°C)	65 ft•lbs (88 Joules)	40 ft•lbs (54 Joules)	20 ft•lbs (27 Joules) Minimum "J" Requirement

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers Company expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the AWS A5.29 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers Company.

TM-811N1

Diameter		Weld Position	Amps	Volts	Wire Feed Speed		Deposition Rate		Contact Tip to Work Distance	
Inches	(mm)				in/min	(m/min)	lbs/hr	(kg/hr)	Inches	(mm)
0.045	(1.2)	All Position	125	24	200	(5.1)	2.0	(0.9)	5/8	(16)
0.045	(1.2)	All Position	200	26	390	(9.9)	7.0	(3.2)	5/8	(16)
0.045	(1.2)	All Position	225	27	455	(11.6)	8.8	(4.0)	3/4	(19)
0.045	(1.2)	Flat & Horizontal	250	28	530	(13.5)	10.0	(4.5)	3/4	(19)
0.052	(1.4)	All Position	125	24	130	(3.3)	3.8	(1.7)	5/8	(16)
0.052	(1.4)	All Position	200	25	225	(5.7)	5.6	(2.5)	5/8	(16)
0.052	(1.4)	Flat & Horizontal	250	26	295	(7.5)	8.1	(3.7)	3/4	(19)
0.052	(1.4)	Flat & Horizontal	300	27	368	(9.4)	10.0	(4.5)	3/4	(19)
1/16	(1.6)	All Position	150	24	120	(3.0)	4.0	(1.8)	3/4	(19)
1/16	(1.6)	All Position	200	25	155	(3.9)	5.7	(2.6)	3/4	(19)
1/16	(1.6)	All Position	250	26	220	(5.6)	7.6	(3.4)	1	(25)
1/16	(1.6)	Flat & Horizontal	300	27	280	(7.1)	10.2	(4.6)	1	(25)

- **Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.**
- The above information was determined by welding using 100% CO₂ shielding gas with a flow rate between 35-50 cfm (16-24 l/min). When welding using 75% Argon (Ar)/25% Carbon Dioxide (CO₂) shielding gas, decrease voltage by 1-2 volts.
- All positions include: Flat, Horizontal, Vertical Up, and Overhead.

STANDARD DIAMETERS AND PACKAGES: For a complete list of diameters and packaging, please contact Hobart Brothers at (800) 424-1543, or (937) 332-5188 for International Customer Service.

Diameter		33-lb. (15kg) Spool	60-lb. (27.2kg) Coil
Inches	(mm)		
0.045	(1.2)	S283612-K29	—
0.052	(1.4)	S283615-K29	—
1/16	(1.6)	S283619-K29	S283619-K02

CONFORMANCE AND APPROVALS:

- **AWS A5.29**, E81T1-Ni1CJ H4, E81T1-Ni1MJ H4
- **AWS A5.29M**, E551T1-Ni1CJ H4, E81T1-Ni1MJ H4
- **ABS** 100% CO₂, 3YSA
- **CWB**, 100% CO₂, E551T1-Ni1C-JH8
- **CWB**, 75-80% Ar/Balance CO₂, E551T1-Ni1M-JH8
- **AWS D1.8**, 75% Ar/25% CO₂ (1/16" diameter electrode)

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJune Road, Miami, FL 33126; OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Material Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers Company is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

Tri-Mark and Hobart are registered trademarks of Hobart Brothers Company, Troy, Ohio.

Revision Date: 131106 (Replaces 130731)

