

Pipeweld 101T-1

An all-positional rutile cored wire for pipe welding of steels with a minimum strength of 610 MPa, for use with M21 shielding gas.

Specifications

Classifications	SFA/AWS A5.29 : E101T1-G EN ISO 18276-A : T 62 4 Mn1Ni P M21 2 H5
Welding Current	DC+
Alloy Type	Low alloy

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 Shielding gas			
As Welded	654 MPa	709 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 Shielding gas		
As Welded	-40 °C	70 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Mo
M21 Shielding gas				
0.06	1.54	0.40	0.97	0.15

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	100-300 A	21-32 V	3.2-14.5 m/min	1.3-5.8 kg/h