Revishield® 61T8

Self-shielded cored wire

Classification

AWS A5.29/A5.29M :E61T8-K6

General description

Self shielded: easiest equipment arrangement
All position welding
Easy to weld in vertical up position
All passes
Good impact and CTOD toughness

Welding positions

ISO/ASME	PA/1G	PB/2F	PC/2G	PF/3G up	PG/3G down	PF/5G up	PG/5G down

Current type / Shielding gases

DC -

Approvals

ABS	DNV	LR
3SA	IIIMSH15	3SH15

Typical chemical composition of all weld metal, (w%)

C	Mn	Si	P	S	Ni	Cr	Al	V	Mo
0.06	0.83	0.05	0.004	0.003	0.57	0.08	0.73	<0.1	<0.1

Mechanical properties of all weld metal

		Shielding gas	Condition	Yield strength (N/mm^2)	Tensile strength (N/mm^2)	Elongation (%)	Impact (ISO), J	
							+20°C	-29°C
Required	AWS A5.29			min 340	410-550	22		27
Typical values after welding			AW	400	490	29		95

Packaging, available sizes and identification

Unit type	Net weight/unit (kg)	Diameter (mm) 2.0
Coils 14C	6.35	X
Coils 50C	22.8	X

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Suggestions for use

For mild and higher strength steel not exceeding the yield strength range
Roundabout groove welds, especially for large diameter heavy tubular constructions
General plate fabrication, including bridge construction, hull plate and stiffener welding on ships and barges, offshore

Materials to be welded

Steel	Code	Type
General structural steel	EN 10025	S 185, S235, S275, S355
Ship plates	ASTM 131	Grade A, B, D, AH32 to DH36
Cast steel	EN 10213-2	G P 240R
Pipe material	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240, L290, L360
	API 5LX	X42, X46, X52
	EN 10216-1/	P235T1, P235T2, P275T1
	EN 10217-1	P275T2, P355N
Boiler & pressure vessel steel	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steel	EN 10113-2	S275, S355
	EN 10113-3	S275, S355

Calculation data

Diameter mm	Electrode Stick-out (mm)	Wire feed speed cm/min	Current (A)	Arc Voltage (B)	Deposition Rate (kg/h)	kg Wire/kg weld metal
2.0	19	125	145	16	1.10	1.32
		230	235	20	1.95	1.32
		280	275	21	2.40	1.32

Welding parameters, optimum fill, Shielding gases Ar+ (>5-25)%CO_2

Diameter	Current /	Welding position						
(mm)	Voltage	PA/1G	PB/2F	PC/2G	PF/3Gup	PE/4G	PF/5G up	PG/5G down
2.0	(A)	275-280	275-280	230-235	200-215	200-215	200-215	200-215
	(V)	21	21	20	19	19	18	18