

# 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.

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

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>M21 Shielding gas</b>			
As Welded	654 MPa (95 ksi)	709 MPa (103 ksi)	25 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>M21 Shielding gas</b>		
As Welded	-40 °C (-40 °F)	70 J (52 ft-lb)

## Typical Weld Metal Analysis %

C	Mn	Si	Ni	Mo
0.06	1.54	0.40	0.97	0.15

## Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate	TTW Dist.
1.2 mm (0.045 in.)	100-300 A	21-32 V	3.2-14.5 m/min (126-571 in./min)	1.3-5.8 kg/h (2.9-12. lb/h)	-