

Dual Shield II 80-Ni1 H4

Dual Shield II 80-Ni1H4 produces diffusible Hydrogen levels of <4mL/100g over a wide range of welding parameters. Applications include petrochemical equipment, bridge fabrication, offshore oil construction, ship fabrication railcar, and heavy machinery.

Classifications:	AWS A5.29:E81T1-Ni1MJ-H4, AWS A5.36:E81T1-M21A6-Ni1-H4, AWS A5.36:E81T1-M21P6-Ni1-H4, ASME SFA 5.29, ASME SFA 5.36
Approvals:	ABS , BV , MIL-E-24403/1 MIL-81T1-Ni1M, LR , CWB E551T1-Ni1M-JH4, DNV-GL
Industry or Segmentation:	Railcars, Mobile Equipment, Industrial and General Fabrication, Civil Construction, Bridge Construction, Ship/Barge Building

Approvals are based on factory location. Please contact ESAB for more information.

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Reduction in Area	Elongation
75% Ar - 25% CO2				
As Welded	545 MPa (79 ksi)	615 MPa (89 ksi)	71 %	28 %
Stress Relieved 2 hr 621 °C (1150 °F)	505 MPa (73 ksi)	570 MPa (84 ksi)	71 %	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
75% Ar - 25% CO2		
As Welded	-29 °C (-20 °F)	149 J (100 ft-lb)
As Welded	-40 °C (-40 °F)	114 J (84 ft-lb)
Stress Relieved 2 hr 620 °C (1150 °F)	-29 °C (-20 °F)	122 J (90 ft-lb)
Stress Relieved 2 hr 620 °C (1150 °F)	-40 °C (-40 °F)	68 J (50 ft-lb)
Stress Relieved 1 hr 593 °C (1100 °F)	-51 °C (-60 °F)	87 J (64 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni
75% Ar - 25% CO2					
0.05	1.20	0.32	0.009	0.014	0.93

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate	Efficiency
75% Ar - 25% CO2					
1.2 mm (.045 in.)	150 A	28 V	508 cm/min (200 in./min)	1.91 kg/h (4.2 lb/h)	86 %
1.2 mm (.045 in.)	210 A	29 V	762 cm/min (300 in./min)	2.86 kg/h (6.3 lb/h)	86 %
1.2 mm (.045 in.)	250 A	30 V	1016 cm/min (400 in./min)	3.86 kg/h (8.5 lb/h)	87 %
1.2 mm (.045 in.)	290 A	33 V	1270 cm/min (500 in./min)	4.85 kg/h (10.7 lb/h)	87 %
1.4 mm (.052 in.)	155 A	25 V	381 cm/min (150 in./min)	2 kg/h (4.4 lb/h)	87 %

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Deposition Data					
Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate	Efficiency
1.4 mm (.052 in.)	245 A	28 V	635 cm/min (250 in./min)	3.31 kg/h (7.3 lb/h)	86 %
1.4 mm (.052 in.)	310 A	33 V	889 cm/min (350 in./min)	4.63 kg/h (10.2 lb/h)	85 %
1.4 mm (.052 in.)	360 A	36 V	1143 cm/min (450 in./min)	6.03 kg/h (13.3 lb/h)	85 %
1.6 mm (1/16 in.)	190 A	27 V	381 cm/min (150 in./min)	2.77 kg/h (6.1 lb/h)	87 %
1.6 mm (1/16 in.)	300 A	30 V	635 cm/min (250 in./min)	4.63 kg/h (10.2 lb/h)	87 %
1.6 mm (1/16 in.)	365 A	33 V	762 cm/min (300 in./min)	5.58 kg/h (12.3 lb/h)	86 %
1.6 mm (1/16 in.)	410 A	33 V	889 cm/min (350 in./min)	6.35 kg/h (14 lb/h)	88 %
2.0 mm (5/64 in.)	250 A	26 V	284 cm/min (112 in./min)	2.9 kg/h (6.4 lb/h)	85 %
2.0 mm (5/64 in.)	350 A	28 V	447 cm/min (176 in./min)	4.76 kg/h (10.5 lb/h)	85 %
2.0 mm (5/64 in.)	450 A	31 V	655 cm/min (258 in./min)	6.71 kg/h (14.8 lb/h)	85 %

Recommended Welding Parameters				
Diameter	Amps	Volts	Wire Feed Speed	TTW Dist.
75% Ar - 25% CO₂				
1.2 mm (.045 in.)	130-200 A	22-26 V	381-660 cm/min (150-260 in./min)	9.5-12.7 mm (3/8-1/2 in.)
1.2 mm (.045 in.)	200-225 A	24-27 V	660-965 cm/min (260-380 in./min)	12.7-19 mm (1/2-3/4 in.)
1.2 mm (.045 in.)	225-265 A	26-29 V	965-1321 mm/min (380-520 in./min)	19-25.4 mm (3/4-1 in.)
1.4 mm (.052 in.)	130-220 A	22-26 V	279-508 cm/min (110-200 in./min)	12.7-15.9 mm (1/2-5/8 in.)
1.4 mm (.052 in.)	220-280 A	25-29 V	508-762 cm/min (200-300 in./min)	15.9-19 mm (5/8-3/4 in.)
1.4 mm (.052 in.)	280-320 A	26-31 V	762-1016 cm/min (300-400 in./min)	19-25.4 mm (3/4-1 in.)
1.6 mm (1/16 in.)	185-290 A	24-28 V	279-559 cm/min (110-220 in./min)	15.9-25.4 mm (5/8-1 in.)
1.6 mm (1/16 in.)	290-350 A	26-30 V	559-838 cm/min (220-330 in./min)	25.4-31.75 mm (1-1.25 in.)