DUAL SHIELD 810X-Ni1

MILD STEEL
FLUX CORED WIRES Tech Data Sheet

TYPICAL MECHANICAL PROPERTIES		
	AS WELDED	
Shielding Gas	CO_2	
Yield Strength, ksi (MPa)	86	590
Tensile Strength, ksi (MPa)	92	635
% Elongation (in 2", 51mm)	29	
TYPICAL CHARPY V-NOTCH IMPACT PROPERTIES		
Shielding Gas	CO_2	
Testing Temperature	FT.-LBS.	(J)
-20ºF (-29ºC)	60	81
-40ºF (-40ºC)	45	61
TYPICAL UNDILUTED WELD METAL ANALYSIS (%)		
Shielding Gas	CO_2	
Carbon	0.04	
Manganese	1.3	
Silicon	0.6	
Phosphorus	0.010	
Sulfur	0.009	
Nickel	1.0	
TYPICAL WELDING RANGE		
Wire Feed Speed	Low	High
	CO_2	
.045"	160	400
.052"	160	250
1/16"	98	250
Volts		
.045"	21.0	27.5
.052"	21.0	26.5
1/16"	20.0	26.5
Amps		
.045"	115	240
.052"	124	250
1/16"	127	263

Typical Welding Parameters on reverse side of the sheet.

Dual Shield 810X-Ni1 is an all-position 1% Nickel flux cored wire for general purpose welding. Dual Shield 810X-Ni1 provides outstanding operator appeal with an easily controlled arc, improved operation at both lower and higher current levels, minimal spatter and easily removed slag. Dual Shield 810X-Ni1 is designed for use with 100% CO_2 . It is an excellent choice for welding on COR-TEN® steel in applications where weathering grade wires are not desirable.

Applications
Power Transmission
Bridges
Shipbuilding
Rail Road Car
General Fabrication
Barges
Light Equipment/Heavy Structural

Welding Process
FCAW

Classifications/Approvals
AWS A5.29; E81T1-Ni1C
Certified by C.W.B.- CSA W48
Seismic Certified

Welding Position
All Position

Filler Metal Type
Low Alloy Steel

Recommended Shielding Gas
CO_2

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TYPICAL WELDING PARAMETERS								
Gas: CO_2			Gas: CO_2			Gas: CO_2		
0.045”			0.052”			1/16”		
WFS	VOLT	AMP	WFS	VOLT	AMP	WFS	VOLT	AMP
160	21.0	115	160	21.0	124	98	20.0	127
184	21.7	128	169	21.6	137	113	20.6	141
208	22.3	140	178	22.1	149	128	21.2	154
232	23.0	153	187	22.7	162	144	21.9	168
256	23.6	165	196	23.2	174	159	22.5	181
280	24.3	178	205	23.8	187	174	23.1	195
304	24.9	190	214	24.3	200	189	23.7	209
328	25.6	203	223	24.9	212	204	24.3	222
352	26.2	215	232	25.4	225	220	25.0	236
376	26.9	228	241	26.0	237	235	25.6	249
400	27.5	240	250	26.5	250	250	26.2	263
Out-of-position welding applications								