

HF-1M

SEAMLESS COPPER-COATED CORED WIRES FOR MILD STEELS



AWS A5.20: E71T-1M H4

AWS A5.20: E71T-9M H4

EN ISO 17632-A : T 46 4 P M21 1 H5

APPROVALS: BV, CE, DNV, LR, TÜV

FEATURES:

- Extremely low diffusible hydrogen weld deposit
- Easy slag removal
- Excellent current transfer
- Very good feeding performance
- Good impact toughness
- Excellent weldability and high productivity

APPLICATIONS

- Steel structures
- Offshore
- Pipelines
- Vessels
- General fabrication
- Heavy equipment

WIRE TYPE

Gas shielded rutile flux-cored wire with rapidly solidifying slag

SHIELDING GAS

80% Ar + 20% CO₂ , Gas flow 15-25 l/min

POLARITY

DC+

WELDING POSITIONS

All Position

TYPICAL DIFFUSIBLE HYDROGEN

<3.0 ml / 100g; Guaranteed for the total processing time < 4.0 ml / 100 g

STANDARD DIAMETERS

1.2mm, 1.4mm, 1.6mm

RE-DRYING

Not required due to seamless wire design

STORAGE

Stored in a dry, enclosed environment, in its original undamaged packaging

PACKAGING

5kg Plastic spool, 15kg Plastic spool, 200kg Drum

DEPOSITED METAL ANALYSIS (WT%, TYPICAL)

Carbon (C)	0.033	Chromium (Cr)	0.020	Phosphorus (P)	0.010
Silicon (Si)	0.490	Nickel (Ni)	0.010	Sulphur (S)	0.005
Manganese (Mn)	1.340	Molybdenum (Mo)	0.010		

MECHANICAL PROPERTY

Yield Strength (Mpa)	Tensile Strength (MPa)	Elongation (%)	Charpy V J/°C
495 (≥390)	555 (490-670)	26 (≥22)	120 / -20 (≥27), 88 / -40

TYPICAL OPERATING PROCEDURE

Diameter (mm)	Volt (V)	Ampere (A)	Electrode Stick-out (mm)	Gas Flow (L/min)
1.2	22-32	220-300	15-20	15-25
1.4	25-33	250-350	15-20	15-25
1.6	25-35	300-400	18-25	15-25

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