

# HF-76

SEAMLESS COPPER-COATED CORED WIRES FOR HIGH STRENGTH STEEL



AWS A5.29 E111T1-K3M H4

EN ISO 18276-A : T 69 4 Mn2NiMo P M21 1 H5

APPROVALS: /

## FEATURES:

- Extremely low diffusible hydrogen weld deposit
- Easy slag removal
- Excellent current transfer
- Very good feeding performance
- Ni-Mo alloyed wire for high strength steel up to 690 MPa YS
- Suit for steel such as HY-100, A514, Q690

## 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% CO<sub>2</sub> , 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

## 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)

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Carbon ( C )	0.054	Chromium (Cr)	0.020	Phosphorus (P)	0.010
Silicon (Si)	0.450	Nickel (Ni)	2.260	Sulphur (S)	0.005
Manganese (Mn)	1.790	Molybdenum (Mo)	0.390		

## MECHANICAL PROPERTY

Yield Strength (Mpa)	Tensile Strength (MPa)	Elongation (%)	Charpy V J/°C
760(≥680)	820(760-900)	19(≥15)	75 / -40(≥27)

## TYPICAL OPERATING PROCEDURE

Diameter (mm)	Volt (V)	Ampere (A)	Electrode Stick-out (mm)	Gas Flow (L/min)
1.2	22-32	180-300	15-20	15-25

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