HG-1F

SEAMLESS COPPER-COATED CORED WIRES FOR MILD STEELS

AWS A5.20：E71T-1C H4 **AWS A5.20：E71T-9C H4** **EN ISO 17632-A : T 42 3 P C1 1 H5**

APPROVALS：ABS，DNV，CCS，LR，CE，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	100% CO_2，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	1.0mm， 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 undameged packaging
PACKAGING	5kg Plastic spool, 15kg Plastic spool, 200kg Drum

DEPOSITED METAL ANALYSIS (WT%,TYPICAL)

Carbon (C)	0.028	Chromium (Cr)	0.020	Phosphorus (P)	0.010
Silicon (Si)	0.320	Nickel (Ni)	0.010	Sulphur (S)	0.004
Manganese (Mn)	1.150	Molybdenum (Mo)	0.010		

MECHANICAL PROPERTY

Yield Strength (Mpa)	Tensile Strength (MPa)	Elongation (%)	Charpy V J/℃
480 (≥390)	530 (490-670)	27 (≥22)	110 / -20 (≥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
1.4	25-33	250-350	15-20	15-25

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