

# HG-81Ni2

SEAMLESS COPPER-COATED CORED WIRES FOR MILD STEELS



AWS A5.29 E81T1-Ni2C-J H4

EN ISO 17632-A : T 46 6 2Ni P C1 1 H5

APPROVALS: /

## FEATURES:

- Extremely low diffusible hydrogen weld deposit
- Easy slag removal
- Excellent current transfer
- Alloyed with 2 % Ni
- Good CVN impact toughness down to -60 °C
- Up to 500 MPa YS.

## 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<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)

Carbon ( C )	0.032	Chromium (Cr)	0.022	Phosphorus (P)	0.010
Silicon (Si)	0.310	Nickel (Ni)	2.020	Sulphur (S)	0.005
Manganese (Mn)	1.270	Molybdenum (Mo)	0.008		

## MECHANICAL PROPERTY

Yield Strength (Mpa)	Tensile Strength (MPa)	Elongation (%)	Charpy V J/°C
610(≥470)	655(550-690)	23(≥19)	55 /-60 (≥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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