

HG-91Ni2

SEAMLESS COPPER-COATED CORED WIRES FOR HIGH STRENGTH STEEL



AWS A5.29 E91T1-Ni2C H4

EN ISO 18276-A : T 55 6 Mn2.5 Ni P C1 1 H5

APPROVALS: /

FEATURES:

- Extremely low diffusible hydrogen weld deposit
- Easy slag removal
- Excellent current transfer
- Ni-Mo-alloyed wire for high strength steel up to 550 MPa YS
- Good CVN impact toughness down to -60 °C
- Alloyed with 2 % Ni

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% 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

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)	0.041	Chromium (Cr)	0.026	Phosphorus (P)	0.017
Silicon (Si)	0.398	Nickel (Ni)	2.347	Sulphur (S)	0.004
Manganese (Mn)	1.415	Molybdenum (Mo)	0.034		

MECHANICAL PROPERTY

Yield Strength (Mpa)	Tensile Strength (MPa)	Elongation (%)	Charpy V J/°C
675(≥540)	725(620-760)	19(≥17)	80 / -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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