

HM-100

SEAMLESS COPPER-COATED CORED WIRES FOR HIGH STRENGTH STEEL



AWS A5.28 E120C-K4

EN ISO 18276-A : T 89 4 Mn2NiMo M M21 1 H5

APPROVALS: /

FEATURES:

- Excellent weldability in flat and horizontal positions.
- H4 diffusible hydrogen levels
- Excellent current transfer
- Very good feeding performance
- Good impact toughness
- Suit for very high strength steel

APPLICATIONS

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

WIRE TYPE

Gas shielded metal-cored wire

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

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)

DEPOSITED METAL ANALYSIS (WT%, TYPICAL)					
Carbon (C)	0.100	Chromium (Cr)	0.370	Phosphorus (P)	0.015
Silicon (Si)	0.770	Nickel (Ni)	2.260	Sulphur (S)	0.009
Manganese (Mn)	1.780	Molybdenum (Mo)	0.580		

MECHANICAL PROPERTY

Yield Strength (Mpa)	Tensile Strength (MPa)	Elongation (%)	Charpy V J/°C
950(≥890)	1110(940-1180)	15(≥15)	62 / -40(≥27)

TYPICAL OPERATING PROCEDURE

Diameter (mm)	Volt (V)	Ampere (A)	Electrode Stick-out (mm)	Gas Flow (L/min)
1.2	14-32	90-300	15-20	15-25

XinXiang HeGuang Technology Co., Ltd.