

# HM-50

SEAMLESS METAL-CORED WIRES FOR MILD STEELS



AWS A5.18: E70C-6M H4

EN ISO 17632-A : T 46 4 M M21 1 H5

APPROVALS: CE, TÜV, LR

## FEATURES:

- High deposition rate and efficiencies
- H4 diffusible hydrogen levels
- Excellent current transfer
- Very good feeding performance
- Good impact toughness
- Virtually no slag coverage

## APPLICATIONS

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

## WIRE TYPE

Gas shielded metal-cored wire

## 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, 1.4mm, 1.6mm

## 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 )	0.052	Chromium (Cr)	0.064	Phosphorus (P)	0.011
Silicon (Si)	0.530	Nickel (Ni)	0.023	Sulphur (S)	0.012
Manganese (Mn)	1.350	Molybdenum (Mo)	0.001		

## MECHANICAL PROPERTY

Yield Strength (Mpa)	Tensile Strength (MPa)	Elongation (%)	Charpy V J/°C
465(≥400)	570(≥490)	27.5(≥22)	120 / -60(≥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
1.4	16-34	120-340	15-25	15-25

**XinXiang HeGuang Technology Co., Ltd.**