

HM-76

SEAMLESS COPPER-COATED CORED WIRES FOR HIGH STRENGTH STEEL



AWS A5.28 E110C-K4 H4

EN ISO 18276-A : T 69 4 M M21 1 H5

APPROVALS: /

FEATURES:

- . High deposition rate and efficiencies
- . H4 diffusible hydrogen levels
- . Excellent current transfer
- . Very good feeding performance
- . Good impact toughness
- . Up to 690 MPa YS

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)	0.060	Chromium (Cr)	0.250	Phosphorus (P)	0.009
Silicon (Si)	0.350	Nickel (Ni)	1.800	Sulphur (S)	0.005
Manganese (Mn)	1.650	Molybdenum (Mo)	0.350		

MECHANICAL PROPERTY

Yield Strength (Mpa)	Tensile Strength (MPa)	Elongation (%)	Charpy V J/°C
760(≥680)	810(≥760)	18(≥15)	75 / -50(≥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.