

HF-55NHM

SEAMLESS COPPER-COATED CORED WIRES FOR WEATHER-RESISTANT STEEL



AWS A5.29 E81T1-G H4

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

APPROVALS: /

FEATURES:

- . Extremely low diffusible hydrogen weld deposit
- . Designed for weathering resistant steel
- . Excellent current transfer
- . Very good feeding performance
- . Good CVN impact toughness down to -40 °C
- . Excellent weldability and high productivity

APPLICATIONS

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

WIRE TYPE

Gas shielded rutile flux-cored wire with rapidly solidifying slag

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)

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Carbon (C)	0.032	Chromium (Cr)	0.440	Phosphorus (P)	0.010
Silicon (Si)	0.460	Nickel (Ni)	0.870	Sulphur (S)	0.007
Manganese (Mn)	1.410	Molybdenum (Mo)	0.023		

MECHANICAL PROPERTY

Yield Strength (Mpa)	Tensile Strength (MPa)	Elongation (%)	Charpy V J/°C
495(≥390)	550(490-670)	27(≥22)	126 / -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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