

HF-55M

SEAMLESS COPPER-COATED CORED WIRES FOR LOW TEMPERATURE STEEL



AWS A5.29 E81T1-Ni1M-J

EN ISO 17632-A : T 46 6 1Ni P M21 1 H5

APPROVALS: DNV

FEATURES:

- Extremely low diffusible hydrogen weld deposit
- Easy slag removal
- Excellent current transfer
- Very good feeding performance
- Up to 500 MPa YS and impact requirements down to -60 °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)	0.010	Phosphorus (P)	0.009
Silicon (Si)	0.380	Nickel (Ni)	0.970	Sulphur (S)	0.006
Manganese (Mn)	1.300	Molybdenum (Mo)	0.010		

MECHANICAL PROPERTY

Yield Strength (Mpa)	Tensile Strength (MPa)	Elongation (%)	Charpy V J/°C
530(≥470)	590(550-690)	25(≥19)	90 /-60(≥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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