

HM-55

SEAMLESS METAL-CORED WIRES FOR MILD STEELS



AWS A5.28 E80C-Ni1 H4

EN ISO 17632-A : T 50 6 1Ni M M21 1 H5

APPROVALS: DNV

FEATURES:

- High deposition rate and efficiencies
- H4 diffusible hydrogen levels
- Excellent current transfer
- Very good feeding performance
- Good impact toughness down to -60°C

APPLICATIONS

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

WIRE TYPE

Gas shielded metal-cored wire

SHIELDING GAS

M21, M20

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)	0.060	Chromium (Cr)	0.030	Phosphorus (P)	0.010
Silicon (Si)	0.570	Nickel (Ni)	1.000	Sulphur (S)	0.005
Manganese (Mn)	1.340	Molybdenum (Mo)	0.150		

MECHANICAL PROPERTY

Yield Strength (Mpa)	Tensile Strength (MPa)	Elongation (%)	Charpy V J/°C
540(≥470)	615(≥550)	26(≥24)	150 / -40(≥27) 135/-50,120/-60

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
1.6	18-36	140-380	15-25	15-25

XinXiang HeGuang Technology Co., Ltd.