BÖHLER HL 75 T-MC

Metal cored wire, seamless, high strength

Classifications

EN ISO 18276-A	EN ISO 18276-B	AWS A5.36	AWS A5.36M
T62 4 Z M M 1 H5	T694T15-1MAP-G-UH5	E101T15-M21A4-G-H4	E691T15-M21A4-G-H4

Characteristics and typical fields of application

Seamless, Nickel-Molybdenum alloyed, metal cored wire for single - or multilayer welding of high strength steels with pure Argon or Ar-CO_2 shielding gas. This wire is especially suitable for pipe welding of special base material like ASTM A519 Gr. 4130; it meets the requirements of NACE requirements.
Features include: high yield, good weldability, excellent bead appearance, low spatter losses and exceptional mechanical properties at low temperatures.

Base materials

30CrMo4
ASTM A519 Gr. 4130

Typical analysis of all-weld metal (wt.-%)

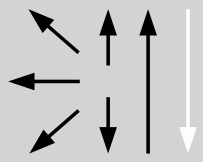
	Gas	C	Si	Mn	Ni	Mo
wt-%	M21	0.10	0.50	1.80	0.90	0.55

Mechanical properties of all-weld metal

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J	
	MPa	MPa	%	-29°C	-40°C
u	**780** (≥620)	**820** (700–830)	**20** (≥17)		**70** (≥47)
a	**670** (≥620)	**750** (700–830)	**22** (≥17)		**60** (≥47)
a1	**720** (≥620)	**800** (700–830)	**20** (≥17)	**55** (≥35)	

u untreated, as welded – shielding gas M21
a annealed 650°C x 4h - shielding gas M21
a1 annealed 650°C x 4h - shielding gas I1

Operating data



Polarity:	Shielding gases:	ø (mm)
DC (+)	(EN ISO 14175) M21; I1	1.2

Welding with standard GMAW-facilities possible

Approvals

ABS (for I1 shielding gas)