# MF-38/US-36 FAMILIARC™

**SAW flux and wire combination**

**Features:**
- Suitable for welding of medium or heavy thick plate
- Excellent mechanical properties

**Classification:** AWS A5.17 F7A6-EH14, F7P6-EH14

**Type of flux:** Fused
**Redrying of flux:** 150~350℃x1h
**Polarity:** AC

## Packaging data

| Flux | Mesh | Can |
|---|---|---|
| MF-38 | 12x65 | 25kg |
| | 20x200 | 25kg |
| | 20xD | 25kg |
| Volume mm | | 240W, 350H, 240L |

| Wire | ϕ mm | Spool | | Coil | | | Drum |
|---|---|---|---|---|---|---|---|
| US-36 | 1.6 | 10kg | 20kg | - | - | - | - |
| | 2.0 | 10kg | 20kg | - | - | - | - |
| | 2.4 | 10kg | - | 25kg | 76kg | - | 300kg |
| | 3.2 | - | - | 25kg | 76kg | - | 300kg |
| | 4.0 | - | - | 25kg | 75kg | 150kg | 300kg |
| | 4.8 | - | - | 25kg | 75kg | 150kg | - |
| | 6.4 | - | - | 25kg | 78kg | 159kg | - |
| Volume mm | | 240W, 110H, 240L | 300W, 110H, 300L | 430W, 90H, 430L | 740W, 110H, 740L | 840W, 110H, 840L | 680ϕ, 770H (2.4ϕmm)<br>600ϕ, 920H (3.2, 4.0ϕmm) |

## Composition (wire mass%)

| | Typical | Guaranty [a] |
|---|---|---|
| C | 0.12 | 0.10~0.20 |
| Si | 0.03 | 0.10 |
| Mn | 1.95 | 1.70~2.20 |
| P | 0.013 | 0.030 |
| S | 0.005 | 0.030 |
| Cu | 0.11 | 0.35 |

Note: [a] Single values are maximum.

## Composition (weld metal mass%)

| | Typical |
|---|---|
| C | 0.09 |
| Si | 0.32 |
| Mn | 1.63 |
| P | 0.018 |
| S | 0.011 |

## Weld mechanical properties

| | Typical | | Guaranty | |
|---|---|---|---|---|
| 0.2%YS (MPa) | 490 | 420 | 400min. | 400min. |
| TS (MPa) | 570 | 530 | 483~655 | 483~655 |
| El on 4d (%) | 30 | 31 | 22min. | 22min. |
| IV -51℃ (J) | 59 | 64 | 27min. | 27min. |
| PWHT (℃xh) | AW | 620x1 | AW | 620±15x1 |