FAMILIARC™ MF-38/ TRUSTARC™ US-40

Flux and wire combination

Features:
- Suitable for butt and fillet welding
- Applicable for 0.5%Mo steel

Classification: AWS A5.23 F9A6-EA3-A3, F8P6-EA3-A3

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

Packaging data

Flux	Mesh	Can	Wire	ϕ mm	Coil	
MF-38	12x65	25kg	US-40	2.4	25kg	-
	20x200	25kg		3.2	25kg	-
	20xD	25kg		4.0	25kg	75kg
	-	-		4.8	25kg	75kg
Volume mm		240W, 350H, 240L	Volume mm		430W, 90H, 430L	740W, 110H, 740L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.13	0.10~0.17
Si	0.02	0.05
Mn	1.80	1.70~2.10
P	0.009	0.025
S	0.014	0.025
Ni	0.02	0.25
Cr	0.06	0.15
Mo	0.52	0.45~0.65
Cu	0.11	0.35

Note: [a] Single values are maximum.

Weld mechanical properties

	Typical		Guaranty	
0.2%YS (MPa)	580	560	538min.	469min.
TS (MPa)	670	630	621~758	552~689
El on 4d (%)	28	29	17min.	20min.
IV -51℃ (J)	51	58	27min.	27min.
PWHT (℃xh)	AW	620x1	AW	620±15x1

Composition (weld metal mass%)

	Typical	Guaranty [a]
C	0.08	0.15
Si	0.34	0.80
Mn	1.58	2.10
P	0.017	0.030
S	0.009	0.030
Mo	0.45	0.40~0.65
Cu	0.12	0.35

Note: [a] Single values are maximum.

Approvals

NK	KAW3Y50M H10

Note: Single electrode