FAMILIARC™ MF-38/ TRUSTARC™ US-A4

Flux and wire combination

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

Classification: AWS A5.23 F8A4-EA4-A4, F8P2-EA4-A4

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-A4	3.2	25kg
	20x200	25kg		4.0	25kg
	20xD	25kg		4.8	25kg
Volume mm		240W, 350H, 240L	Volume mm		430W, 90H, 430L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.09	0.07~0.12
Si	0.04	0.05
Mn	1.59	1.25~1.70
P	0.01	0.025
S	0.014	0.025
Ni	0.02	0.25
Cr	0.04	0.15
Mo	0.52	0.45~0.60
Cu	0.10	0.35

Note: [a] Single values are maximum.

Composition (weld metal mass%)

	Typical	Guaranty [a]
C	0.10	0.15
Si	0.39	0.80
Mn	1.35	1.60
P	0.013	0.030
S	0.013	0.030
Mo	0.52	0.40~0.65
Cu	0.11	0.35

Note: [a] Single values are maximum.

Weld mechanical properties

	Typical		Guaranty	
0.2%YS (MPa)	520	510	469min.	
TS (MPa)	640	600	552~689	
El on 4d (%)	28	29	20min.	
IV (J)	-40℃: 37	-51℃: 40	-40℃: 27min.	-51℃: 27min.
PWHT (℃xh)	AW	620x1	AW	620±15x1