MF-53/US-W52B FAMILIARC™

Flux and wire combination

Features:
- Suitable for fillet welding
- Excellent bead appearance and good slag removal

Classification: AWS A5.23 F7A0-EG-G

Redrying Conditions: 150~350℃x1h

Polarity: AC

Packaging data

Flux	Mesh	Can			
MF-53	8x48	20kg			
Volume mm		240W, 350H, 240L			
Wire	**ϕ mm**	**Spool**		**Coil**	
US-W52B	1.6	10kg	20kg	-	-
	2.0	10kg	20kg	-	-
	2.4	10kg	-	-	-
	3.2	-	-	25kg	76kg
	4.0	-	-	25kg	75kg
	4.8	-	-	25kg	-
Volume mm		240W, 110H, 240L	300W, 110H, 300L	430W, 90H, 430L	740W, 110H, 740L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.10	0.15
Si	0.03	0.10
Mn	1.51	1.20~1.80
P	0.010	0.025
S	0.004	0.025
Ni	0.14	0.10~0.25
Cr	0.62	0.50~0.80
Cu	0.36	0.30~0.55

Composition (weld metal mass%)

	Typical
C	0.05
Si	0.58
Mn	1.35
P	0.009
S	0.007
Ni	0.18
Cr	0.59
Cu	0.36

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	430	400min.
TS (MPa)	530	483~655
El on 4d (%)	23	22min.
IV -18℃ (J)	35	27min.