MG-50 FAMILIARC™

Solid wire

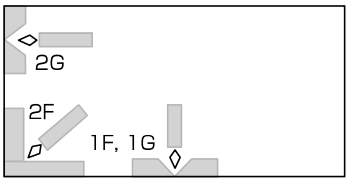
Features: ▪ Higher currents are recommended

Classification: AWS A5.18 ER70S-G

Shielding gas: CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool			Drum		
1.0	-	-	20kg	-	-	-
1.2	10kg	15kg	20kg	-	300kg	-
1.4	-	15kg	20kg	250kg	-	400kg
1.6	-	-	20kg	-	-	400kg
Volume mm	240W, 110H, 240L	300W, 110H, 300L		530ϕ, 820H		680ϕ, 770H

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.04	0.02~0.15
Si	0.73	0.55~1.10
Mn	1.58	1.40~1.90
P	0.010	0.030
S	0.010	0.030
Cu	0.23	0.50
Ti+Zr	0.22	0.02~0.30

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G
1.0	50~220	50~200
1.2	100~350	100~300
1.4	150~450	150~350
1.6	200~550	200~400

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	490	420	400min.
TS (MPa)	570	530	483min.
El on 4d (%)	30	34	22min.
IV -18℃ (J)	100	110	0℃: 47min.
PWHT (℃xh)	AW	625x1	AW

Approvals

	CO_2	Ar-CO_2
ABS	3YSA	3SA, 3YSA
LR	3YS, H15	
DNV	ⅢYMS	
BV	SA3M, SA3YM	SA3YM
NK	KSW53G (C)	KSW53G (M2)
CR	3YS	-
KR	3YSG (C)	-
CCS	3Y	-