MG-50T FAMILIARC™

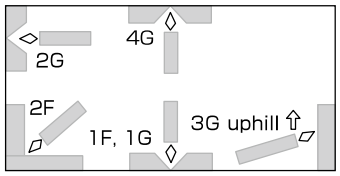
Solid wire

Features:
- Suitable for butt and fillet welding in all positions
- Suitable for lower currents

Classification: AWS -

Shielding gas: CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool		Drum	
0.9	10kg	20kg	250kg	-
1.0	10kg	20kg	250kg	-
1.2	10kg	20kg	-	300kg
Volume mm	240W, 110H, 240L	300W, 110H, 300L	530ϕ, 820H	

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.05	0.02~0.15
Si	0.75	0.50~1.00
Mn	1.34	1.25~2.00
P	0.010	0.030
S	0.013	0.030
Cu	0.24	0.50

Note: [a] Single values are maximum.

Approvals

	CO_2	Ar-CO_2
ABS	3YSA	
LR	3YS, H15	
DNV	ⅢYMS	
BV	SA3M, SA3YM	
NK	KSW53G (C) KWS53Y40G (C)	KSW53G (M2)
CR	3YS	
KR	3YSG (C)	-

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	460	360	390min.
TS (MPa)	540	490	490~600
El on 4d (%)	31	34	18min. (5d)
IV -18℃ (J)	100	110	0℃: 27min.
PWHT (℃xh)	AW	625x2	AW

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill	4G
0.9	50~200	50~180	50~140	50~120
1.0	50~220	50~200	50~140	50~120
1.2	80~350	80~300	50~160	50~140