MG-51T FAMILIARC™

Solid wire

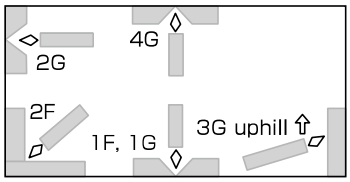
Features:
- Higher currents can be applied in vertical and overhead positions
- Suitable for pipe welding in all positions

Classification: AWS A5.18 ER70S-6

Shielding gas: CO_2, Ar-20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

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

Composition (wire mass%)

	Typical (CO_2)	Guaranty [a]
C	0.10	0.06~0.15
Si	0.88	0.80~1.15
Mn	1.56	1.40~1.85
P	0.011	0.025
S	0.012	0.035
Ni	0.01	0.15
Cr	0.02	0.15
Mo	<0.01	0.15
Cu	0.24	0.50
V	<0.01	0.03

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	470	520	400min.
TS (MPa)	560	600	483min.
El on 4d (%)	32	31	22min.
IV -29℃ (J)	70	90	27min.
SG	CO_2	Ar-20%CO_2	CO_2

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