MG-60 TRUSTARC™

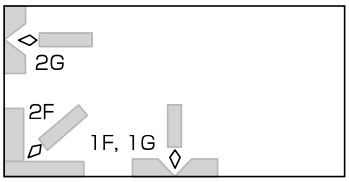
Solid wire

Features: ▪ Suitable for flat, horizontal and horizontal fillet welding

Classification: -

Shielding gas: CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
0.9	20kg
1.2	20kg
1.4	20kg
1.6	20kg
Volume mm	280W, 110H, 270L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.04	0.12
Si	0.82	0.60~1.00
Mn	1.95	1.40~2.10
P	0.013	0.025
S	0.010	0.025
Mo	0.35	0.10~0.45
Cu	0.25	0.50
Ti	0.20	0.02~0.30

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G
0.9	50~200	50~180
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)	590	570	500min.
TS (MPa)	670	660	552min.
El on 4d (%)	28	29	19min.
IV -18℃ (J)	90	80	-5℃: 47min.
PWHT (℃xh)	AW	620x5	AW

Approvals

ABS	3YQ500
DNV	ⅢY46MS, MG
NK	KSW3Y50G (C) H5