MG-70 TRUSTARC™

Solid wire

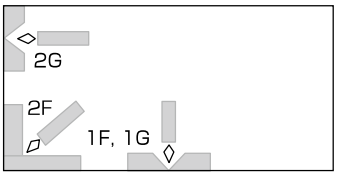
Features: ▪ Suitable for 690MPa tensile strength steel

Classification: AWS A5.28 ER100S-G

Shielding gas: CO_2

Polarity: DCEP

Welding Positions:



Packaging data

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

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.06	0.12
Si	0.78	0.50~1.00
Mn	2.00	1.70~2.30
P	0.011	0.030
S	0.007	0.030
Ni	1.05	0.70~1.50
Mo	0.64	0.40~0.90
Cu	0.23	0.35

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G
1.2	100~300
1.6	200~450

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	610	550min.
TS (MPa)	720	690min.
El on 4d (%)	26	16min.
IV -18℃ (J)	90	27min.