MG-S1CM TRUSTARC™

Solid wire for 1~1.25%Cr-0.5%Mo steel

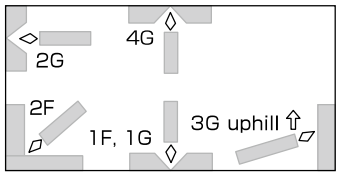
Features: ▪ Applied for ASTM A387 Gr.11, Gr.12 and equivalents

Classification: AWS A5.28 ER80S-B2Mn

Shielding gas: Ar-2~5%O_2, Ar-5~20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool		Drum		
0.8	10kg	-	-	-	-
0.9	10kg	-	-	-	-
1.0	10kg	20kg	-	-	-
1.2	10kg	20kg	250kg	300kg	400kg
1.4	10kg	-	-	-	-
1.6	-	20kg	-	-	400kg
Volume mm	240W, 110H, 230L	280W, 110H, 270L	530ϕ, 820H		680ϕ, 770H

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.07	0.12
Si	0.55	0.30~0.90
Mn	1.05	0.80~1.50
P	0.007	0.025
S	0.008	0.025
Cr	1.38	1.00~1.60
Mo	0.56	0.40~0.65
Cu	0.26	0.40

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G, 3G uphill, 4G
1.2	240~300	130~190

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	550	570	469min.
TS (MPa)	640	680	552min.
El on 4d (%)	25	22	17min.
IV 0℃ (J)	190	70	-
PWHT (℃xh)	650x1	620x1	620±15x1
SG	Ar-2%O_2	Ar-20%CO_2	Ar-2%O_2

Approvals

ABS	MG
LR	MG
BV	UP (AWS A 5.28 ER80S-G)
NK	MG