MG-S1N TRUSTARC™

Solid wire

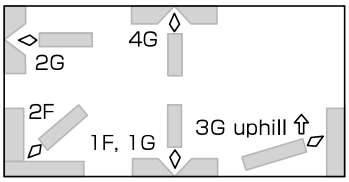
Features: ▪ Suitable for low temperature steel

Classification: AWS A5.28 ER70S-G

Shielding gas: Ar-5~20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

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

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.04	0.07
Si	0.43	0.20~0.60
Mn	1.37	1.00~1.60
P	0.003	0.020
S	0.008	0.020
Ni	1.76	1.50~2.00
Mo	0.20	0.40
Cu	0.21	0.50

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
1.2	80~300	50~180

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	410	360min.
TS (MPa)	520	483min.
El on 4d (%)	32	22min.
IV -60℃ (J)	140	27min.
PWHT (℃xh)	620x1	620±15x1
SG	Ar-20%CO_2	Ar-20%CO_2