MG-S3N TRUSTARC™

Solid wire

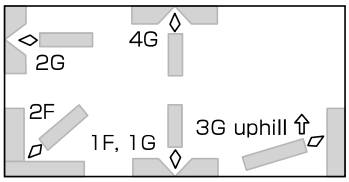
Features: ▪ Suitable for 3.5% Ni steel

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	0.02	0.07
Si	0.29	0.50
Mn	1.24	1.00~1.50
P	0.006	0.020
S	0.002	0.020
Ni	4.16	3.80~4.50
Mo	0.21	0.40
Cu	0.22	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)	470	360min.
TS (MPa)	570	483min.
El on 4d (%)	32	16min.
IV (J)	-101℃: 130	-105℃: 27min.
PWHT (℃xh)	620x1	620±15x1
SG	Ar-5%CO_2	Ar-5%CO_2