MG-S50 FAMILIARC™

Solid wire

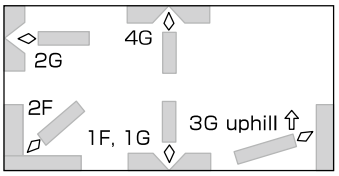
Features: ▪ Suitable for butt and fillet welding in all positions

Classification: AWS A5.18 ER70S-G

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

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool		Drum		
0.8	10kg	-	-	-	-
0.9	10kg	20kg	-	-	-
1.0	10kg	20kg	100kg	-	-
1.2	10kg	20kg	-	250kg	-
1.4	-	20kg	-	-	-
1.6	10kg	20kg	-	-	400kg
Volume mm	240W, 110H, 240L	300W, 110H, 300L	530ϕ, 820H		680ϕ, 770H

Composition (wire mass%)

	Typical (Ar-20%CO_2)	Guaranty [a]
C	0.10	0.02~0.15
Si	0.75	0.40~1.00
Mn	1.38	0.90~1.60
P	0.011	0.030
S	0.012	0.030
Cu	0.24	0.50

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill	4G
0.8	50~180	50~180	50~140	50~120
0.9	50~200	50~180	50~140	50~120
1.0	50~220	50~200	50~140	50~120
1.2	80~300	80~300	50~160	50~140
1.4	150~400	150~350	-	-
1.6	200~450	200~400	-	-

All-weld mechanical properties

	Typical		Typical		Guaranty
0.2%YS (MPa)	450	370	490	400	400min.
TS (MPa)	570	520	590	540	483min.
El on 4d (%)	28	32	33	33	22min.
IV -29℃ (J)	180	190	180	200	27min.
PWHT (℃xh)	AW	620x1	AW	620x1	AW
SG	Ar-20%CO_2		Ar-2%O_2		Ar-20%CO_2 & Ar-2%O_2

Approvals

ABS	3YSA
LR	3YS
DNV	ⅢYMS