MG-S50LT TRUSTARC™

Solid wire

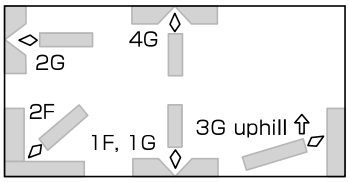
Features: ▪ Suitable for 400 to 490MPa tensile strength steel

Classification: AWS A5.18 ER70S-G

Shielding gas: Ar-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	0.07	0.03~0.10
Si	0.40	0.30~0.50
Mn	1.91	1.50~2.10
P	0.006	0.015
S	0.002	0.015
Cu	0.21	0.40
Ti	0.08	0.04~0.12
B	0.006	0.003~0.010

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	440	400min.
TS (MPa)	540	510	483min.
El on 4d (%)	33	35	22min.
IV -60℃ (J)	110	88	27min.
PWHT (℃xh)	AW	620x1	AW & 620±15x1

Approvals

ABS	3YSA, MG
LR	5Y40S (H15)
DNV	ⅤYMS, VL2-4L, 4-4L
NK	KSWL3G (M2)