MG-S56 TRUSTARC™

Solid wire for Mn-Mo & Mn-Mo-Ni steel

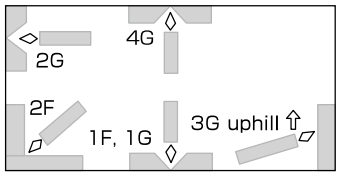
Features: ▪ Applied for ASTM A533 Type A, B, C, D and equivalents

Classification: AWS A5.28 ER80S-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	0.06	0.10
Si	0.41	0.30~0.90
Mn	1.50	1.00~1.60
P	0.004	0.020
S	0.007	0.020
Ni	0.92	0.50~1.00
Mo	0.35	0.20~0.60
Cu	0.16	0.35

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)	540	469min.
TS (MPa)	620	552min.
El on 4d (%)	29	19min.
IV -20℃ (J)	190	-
PWHT (℃xh)	620x1	620±15x1
SG	Ar-20%CO_2	Ar-20%CO_2