MG-S63B TRUSTARC™

Solid wire

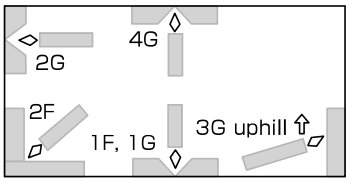
Features: ▪ Suitable for 550 to 610MPa tensile strength steel

Classification: AWS A5.28 ER90S-G

Shielding gas: Ar-5~25%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	0.02~0.15
Si	0.71	0.50~0.90
Mn	1.36	1.10~1.60
P	0.006	0.025
S	0.012	0.025
Cr	0.45	0.30~0.60
Mo	0.28	0.10~0.45
Cu	0.25	0.40
Ti	0.08	0.02~0.30

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill, 4G
1.2	80~350	80~300	50~160

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	580	500min.
TS (MPa)	660	621min.
El on 4d (%)	29	19min.
IV -18℃ (J)	150	-5℃: 47min.
SG	Ar-20%CO_2	Ar-20%CO_2