MG-S63S TRUSTARC™

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

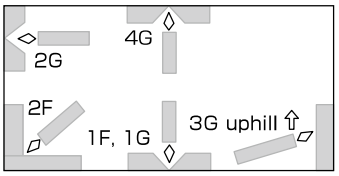
Features: ▪ Applied for ASTM A533 Type A, B, C, D class 2 and equivalents

Classification: AWS A5.28 ER90S-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	0.08	0.15
Si	0.48	0.70
Mn	1.76	1.50~2.10
P	0.007	0.015
S	0.002	0.015
Ni	1.02	0.80~1.40
Mo	0.46	0.40~0.65
Cu	0.12	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)	570	-
TS (MPa)	650	621min.
El on 4d (%)	27	-
IV -12℃ (J)	150	-
PWHT (℃xh)	630x27	620±15x1
SG	Ar-20%CO_2	Ar-20%CO_2