MG-S70 TRUSTARC™

Solid wire

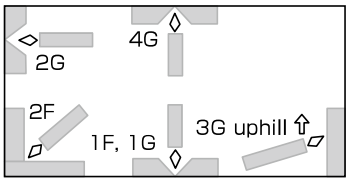
Features: ▪ Suitable for 690MPa tensile strength steel

Classification: AWS A5.28 ER100S-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	0.11
Si	0.47	0.30~0.80
Mn	1.41	0.90~1.60
P	0.010	0.030
S	0.008	0.030
Ni	2.02	1.50~2.50
Cr	0.17	0.30
Mo	0.39	0.20~0.60
Cu	0.21	0.50

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)	650	550min.
TS (MPa)	720	690min.
El on 4d (%)	25	16min.
IV -40℃ (J)	100	27min.
SG	Ar-20%CO_2	Ar-20%CO_2