MG-S70SA1 TRUSTARC™

Solid wire for 0.5%Mo steel

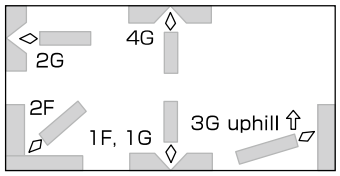
Features: ▪ Applied for ASTM A204 Gr. A, B, C and equivalents

Classification: AWS A5.28 ER70S-A1

Shielding gas: Ar-2~5%O_2, Ar-5~20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool		Drum	
0.9	10kg	-	-	-
1.0	-	20kg	250kg	-
1.2	-	20kg	250kg	400kg
Volume mm	240W, 110H, 230L	280W, 110H, 270L	530ϕ, 820H	680ϕ, 770H

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.04	0.12
Si	0.51	0.30~0.70
Mn	0.99	1.30
P	0.009	0.025
S	0.012	0.025
Ni	0.03	0.20
Mo	0.49	0.40~0.65
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)	450	400min.
TS (MPa)	530	515min.
El on 4d (%)	33	19min.
IV 0℃ (J)	190	-
PWHT (℃xh)	620x1	620±15x1
SG	Ar-2%O_2	Ar-2%O_2