MG-S80 TRUSTARC™

Solid wire

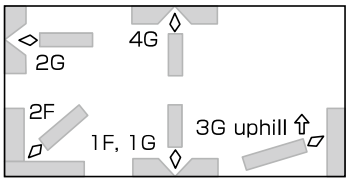
Features: ▪ Suitable for 780MPa tensile strength steel

Classification: AWS A5.28 ER110S-G

Shielding gas: Ar-5~25%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	20kg
Volume mm	300W, 110H, 300L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.05	0.12
Si	0.51	0.20~0.70
Mn	1.37	1.10~1.70
P	0.011	0.025
S	0.002	0.025
Ni	2.64	2.40~2.90
Cr	0.16	0.05~0.35
Mo	0.47	0.35~0.70
Ti	0.11	0.02~0.30
Cu	0.22	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)	770	665min.
TS (MPa)	850	759min.
El on 4d (%)	20	15min.
IV -40℃ (J)	80	27min.
SG	Ar-20%CO_2	Ar-20%CO_2

Approvals

ABS	MG
DNV	ⅣY69MS
NK	KSW4Y69G (M2)