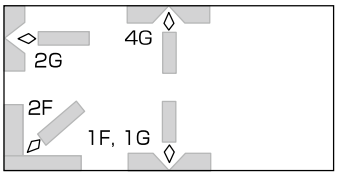
MG-S80B2F TRUSTARC™

Solid wire for 1~1.25%Cr-0.5%Mo steel

Features:
- Applied for ASTM A387 Gr.11 and equivalents
- Suitable for 1 pass fillet welding in the panel fin tube fabrication
- Do not use for multi-pass welding

Welding Positions:



Classification: AWS A5.28 ER80S-B2

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

Polarity: DCEP

Packaging data

ϕ mm	Spool		Drum	
0.9	10kg	20kg	-	-
1.0	10kg	20kg	250kg	-
1.2	10kg	20kg	250kg	400kg
1.4	10kg	20kg	-	-
1.6	10kg	20kg	-	400kg
Volume mm	240W, 110H, 230L	280W, 110H, 270L	530ϕ, 820H	680ϕ, 770H

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.11	0.07~0.12
Si	0.50	0.40~0.70
Mn	0.67	0.47~0.70
P	0.004	0.025
S	0.004	0.025
Cr	1.40	1.20~1.50
Ni	0.01	0.20
Mo	0.55	0.40~0.65
Cu	0.15	0.35

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G, 4G
1.2	240~300	130~190

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	550	470min.
TS (MPa)	650	550min.
El on 4d (%)	28	19min.
IV -18℃ (J)	140	-
PWHT (℃xh)	620x1	620±15x1
SG	Ar-2%O_2	Ar-2%O_2