MG-S88A TRUSTARC™

Solid wire

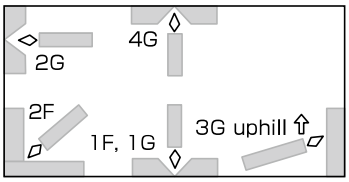
Features: ▪ Suitable for 780MPa tensile strength steel for low temperature service

Classification: AWS A5.28 ER120S-G

Shielding gas: Ar-20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool	
1.2	10kg	20kg
Volume mm	240W, 110H, 230L	280W, 110H, 270L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.06	0.09
Si	0.50	0.30~0.70
Mn	1.48	1.30~1.70
P	0.004	0.020
S	0.002	0.020
Ni	3.51	3.20~3.80
Mo	0.76	0.60~0.90
Cu	0.23	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	690min.
TS (MPa)	880	828min.
El on 4d (%)	22	15min.
IV (J)	-80℃: 78	-60℃: 27min.

Approvals

ABS	4AQ690SAH5, MG
LR	4Y69S H5, MG
DNV	ⅣY69MS (H5), MG
BV	SA4Y69M H5, MG
NK	KSW4Y69G (M2) H5
CCS	4Y69H5, MG