MG-SM TRUSTARC™

Solid wire for 0.5%Mo steel

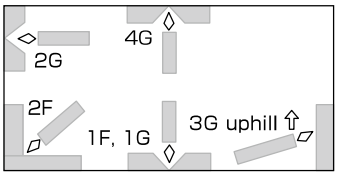
Features: ▪ Applied for ASTM A204 Gr. A, B, C and equivalents

Classification: AWS A5.28 ER80S-G

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	20kg	-	-	-
1.0	10kg	20kg	-	-	-
1.2	10kg	20kg	100kg	250kg	400kg
Volume mm	240W, 110H, 230L	280W, 110H, 270L	530ϕ, 820H		680ϕ, 770H

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.07	0.12
Si	0.53	0.30~0.70
Mn	1.03	0.60~1.30
P	0.006	0.025
S	0.008	0.025
Ni	0.02	0.20
Mo	0.54	0.40~0.65
Cu	0.17	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)	520	480	469min.
TS (MPa)	610	580	552min.
El on 4d (%)	25	28	19min.
IV 0℃ (J)	100	160	-
PWHT (℃xh)	AW	620x1	AW
SG	Ar-20%CO_2	Ar-20%CO_2	Ar-20%CO_2

Approvals

ABS	MG (AWS A5.28 ER80S-G)
LR	MG