MG-W50TB FAMILIARC™

Solid wire

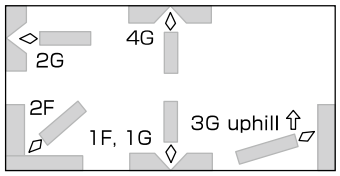
Features:
- Applicable for weatherproof steel
- Lower currents are suitable

Classification: AWS A5.28 ER80S-G

Shielding gas: CO_2, Ar-20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool	
0.9	-	20kg
1.0	10kg	-
1.2	10kg	20kg
Volume mm	240W, 110H, 240L	300W, 110H, 300L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.03	0.12
Si	0.77	0.50~0.90
Mn	1.35	1.00~1.80
P	0.008	0.030
S	0.013	0.030
Ni	0.18	0.10~0.80
Cr	0.61	0.50~0.80
Cu	0.45	0.30~0.60

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill, 4G
0.9	50~200	50~180	50~120
1.0	50~220	50~200	50~120
1.2	80~320	80~300	50~140

All-weld mechanical properties

	Typical		Guaranty	
0.2%YS (MPa)	450	480	400min.	400min.
TS (MPa)	560	580	552min.	552min.
El on 4d (%)	30	29	19min.	19min.
IV (J)	0℃: 110	-18℃: 120	0℃: 47min.	-18℃: 47min.
SG	CO_2	Ar-20%CO_2	CO_2	Ar-20%CO_2