# MIX-50 FAMILIARC™

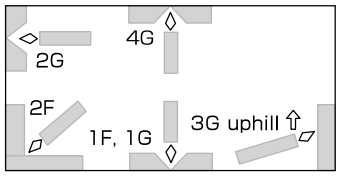
**Solid wire**

**Features:**
- Suitable for butt and fillet welding in all positions
- Suitable for lower currents

**Classification:** AWS A5.18 ER70S-3

**Shielding gas:** Ar-20%$CO_2$
**Polarity:** DCEP

**Welding Positions:**




## Packaging data

| ϕ mm | Spool | | Drum | |
|---|---|---|---|---|
| 0.9 | 10kg | 20kg | 250kg | - |
| 1.0 | 10kg | 20kg | 250kg | - |
| 1.2 | - | 20kg | - | 300kg |
| **Volume mm** | 240W, 110H, 240L | 300W, 110H, 300L | 530ϕ, 820H | |

## Composition (wire mass%)

| | Typical | Guaranty [a] |
|---|---|---|
| **C** | 0.10 | 0.06~0.15 |
| **Si** | 0.55 | 0.45~0.75 |
| **Mn** | 1.11 | 0.90~1.40 |
| **P** | 0.012 | 0.025 |
| **S** | 0.011 | 0.035 |
| **Cu** | 0.24 | 0.50 |
| **Ni** | 0.01 | 0.15 |
| **Cr** | 0.03 | 0.15 |
| **Mo** | <0.01 | 0.15 |
| **V** | <0.01 | 0.03 |

Note: [a] Single values are maximum.

## All-weld mechanical properties

| | Typical | Guaranty |
|---|---|---|
| **0.2%YS (MPa)** | 440 | 400min. |
| **TS (MPa)** | 540 | 483min. |
| **El on 4d (%)** | 32 | 22min. |
| **IV -18℃ (J)** | 170 | 27min. |
| **PWHT** | AW | AW |

## Approvals

| | |
|---|---|
| **ABS** | 3YSA |
| **NK** | KSW53G (M2) |

## Welding parameters (A)

| ϕ mm | 1F, 1G, 2F | 2G | 3G uphill | 4G |
|---|---|---|---|---|
| 0.9 | 50~200 | 50~180 | 50~140 | 50~120 |
| 1.0 | 50~220 | 50~200 | 50~140 | 50~120 |
| 1.2 | 80~350 | 80~300 | 50~160 | 50~140 |