MIX-50S FAMILIARC™

Solid wire

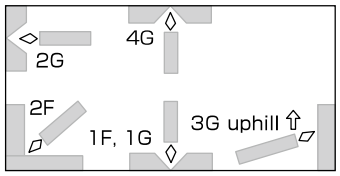
Features:
- Suitable for butt and fillet welding in all positions
- Suitable for higher currents

Classification: AWS A5.18 ER70S-G

Shielding gas: Ar-20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool	Drum		
0.9	20kg	-	-	-
1.0	-	250kg	-	-
1.2	20kg	250kg	300kg	-
1.4	20kg	250kg	-	-
1.6	20kg	-	-	400kg
Volume mm	300W, 110H, 300L	530ϕ, 820H		680ϕ, 770H

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.06	0.02~0.15
Si	0.57	0.40~1.00
Mn	1.17	1.00~1.60
P	0.009	0.030
S	0.011	0.030
Cu	0.24	0.50
Ti+Zr	0.07	0.02~0.15

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	470	400min.
TS (MPa)	550	483min.
El on 4d (%)	32	22min.
IV -18℃ (J)	170	27min.

Approvals

ABS	3YSA
LR	3YS, H15
DNV	ⅢYMS
BV	SA3YM
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
1.4	150~400	150~350	-	-
1.6	200~450	200~400	-	-