MX-55LF TRUSTARC™

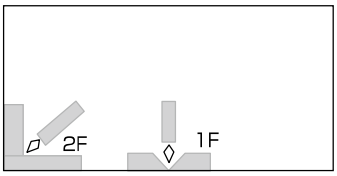
Flux cored wire

Features:
- Excellent porosity resistibility to inorganic zinc primer
- Excellent impact value down to -60℃

Classification: AWS A5.20 E70T-9C-J

Shielding gas: CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool		Drum
1.2	15kg	-	-
1.4	15kg	-	150kg
1.6	-	20kg	-
Volume mm	300W, 110H, 300L		530ϕ, 820H

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.05	0.12
Si	0.44	0.90
Mn	1.42	1.75
P	0.01	0.03
S	0.01	0.03
Ni	0.34	0.50
Cr	0.03	0.20
Mo	0.01	0.30
Cu	0.02	0.35
V	0.01	0.08

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F	2F
1.2	150~300	180~300
1.4	170~400	200~350
1.6	200~450	270~400

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	540	400min.
TS (MPa)	590	483~655
El on 4d (%)	29	22min.
IV -60℃ (J)	58	27min.

Approvals

	Single	Tandem
ABS	3YSA, MG	3YA, MG
LR	5Y40S H5	-
DNV	VYMS	-
BV	SA3YM, UP	A3YM, UP
NK	KSW54G (C), KSWL3G (C)	KAWL3MPG (C)