MX-A55Ni1 TRUSTARC™

Flux cored wire

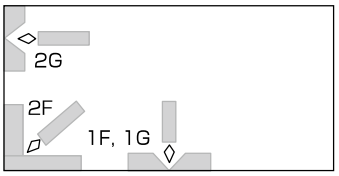
Features: ▪ Excellent impact values down to -60℃

Classification: AWS A5.28 E80C-G

Shielding gas: Ar-20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	15kg
Volume mm	300W, 110H, 300L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.05	0.15
Si	0.34	0.80
Mn	1.67	1.40~2.00
P	0.007	0.030
S	0.008	0.030
Ni	0.86	0.70~1.00
Cr	0.02	0.15
Mo	0.01	0.20
V	<0.01	0.05
Cu	0.03	0.30

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G
1.2	150~300	150~300

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	540	470min.
TS (MPa)	610	552~680
El on 4d (%)	29	20min.
IV -60℃ (J)	120	27min.