MX-A55T TRUSTARC™

Flux cored wire

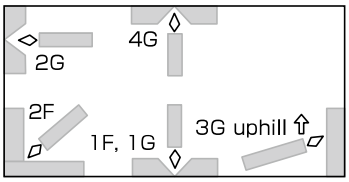
Features:
- Suitable with a short circuit arc
- Excellent impact value down to -60℃

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	0.40	0.80
Mn	1.40	0.50~1.75
P	0.010	0.030
S	0.014	0.030
Ni	1.42	1.00~2.00
Cr	0.02	0.15
Mo	0.01	0.20
V	0.01	0.05
Cu	0.04	0.30

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
1.2	50~300	50~180

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	540	469min.
TS (MPa)	600	552~689
El on 4d (%)	29	19min.
IV -60℃ (J)	90	27min.

Approvals

LR	5Y40S, H5
DNV	ⅤYMS (H5)
BV	SA3YM H5, UP