MX-A80L TRUSTARC™

Flux cored wire

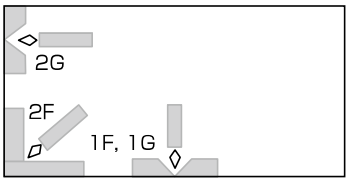
Features: ▪ Excellent impact values down to -60℃

Classification: AWS A5.28 E110C-G H4

Shielding gas: Ar-20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	12.5kg
Volume mm	300W, 110H, 300L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.06	0.03~0.10
Si	0.48	0.90
Mn	1.87	1.1~2.0
P	0.009	0.020
S	0.009	0.020
Ni	2.49	2.1~3.0
Cr	0.01	0.2
Mo	0.09	0.2
V	<0.01	0.05
Nb	<0.01	0.05

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)	720	676min.
TS (MPa)	800	759~896
El on 4d (%)	24	15min.
IV -60℃ (J)	120	47min.

Approvals

ABS	5YQ690SA (H5)
LR	5Y69S, H5
DNV	ⅤY69MS (H5)