

FCAW

MX-100T

FAMILIARC™

Flux cored wire

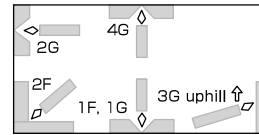
- Features:**
- Suitable for thin plates (e.g., 0.8mm)
 - Excellent arc stability in low current range (50~180A) for short circuiting welding

Classification: AWS A5.18 E70C-6C/6M

Shielding gas: CO₂ or Ar-CO₂

Polarity: DCEP

Welding Positions:



Packaging data

φ mm	Spool	Drum
1.2	20kg	250kg
1.4	20kg	250kg
Volume mm	300W, 110H, 300L	530 φ, 820H

Composition (all-weld metal mass%)

	Typical (CO ₂)	Guaranty ^a
C	0.08	0.12
Si	0.49	0.90
Mn	1.53	1.75
P	0.01	0.03
S	0.01	0.03
Ni	0.01	0.50
Cr	0.02	0.20
Mo	0.01	0.30
V	<0.01	0.08
Cu	0.02	0.50

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
1.2	50~300	50~180
1.4	80~400	70~180

All-weld mechanical properties

	Typical (CO ₂)	Guaranty
0.2%YS (MPa)	480	400min.
TS (MPa)	560	490min.
EI on 4d (%)	31	22min.
IV -29°C (J)	62	27min.

Approvals

	CO ₂	Ar-CO ₂
ABS	3YSA, H5	-
LR	3YS, H5	-
DNV-GL	III YMS (H5)	-
BV	SA3YM (H5)	-
CR	3YS-HH	-