

GMAW

MG-51T

FAMILIARC™

Solid wire

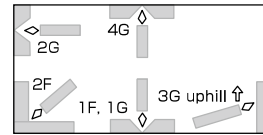
- Features:**
- Higher currents can be applied in vertical and overhead positions
 - Suitable for pipe welding in all positions

Classification: AWS A5.18 ER70S-6

Shielding gas: CO₂, Ar-20%CO₂

Polarity: DCEP

Welding Positions:



Packaging data

φ mm	Spool	Drum	
0.9	20kg	-	-
1.0	20kg	250kg	-
1.2	20kg	-	300kg
Volume mm	300W, 110H, 300L	530 φ, 820H	

Composition (wire mass%)

	Typical (CO ₂)	Guaranty ^a
C	0.10	0.06~0.15
Si	0.88	0.80~1.15
Mn	1.56	1.40~1.85
P	0.011	0.025
S	0.012	0.035
Ni	0.01	0.15
Cr	0.02	0.15
Mo	<0.01	0.15
Cu	0.24	0.50
V	<0.01	0.03

Note: ^a Single values are maximum.

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	470	520	400min.
TS (MPa)	560	600	483min.
EI on 4d. (%)	32	31	22min.
IV -29°C (J)	70	90	27min.
SG	CO ₂	Ar-20%CO ₂	CO ₂

Welding parameters (A)

φ mm	1F, 1G, 2F	2G	3G uphill	4G
0.9	50~200	50~180	50~140	50~120
1.0	50~220	50~200	50~140	50~120
1.2	80~350	80~300	50~160	50~140