

FCAW

MX-A100

FAMILIARC™

Flux cored wire

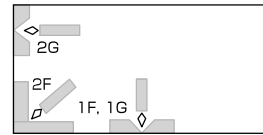
Features: ■ Better arc stability and wider optimum current range for spray transfer arc with less spattering than solid wire

Classification: AWS A5.18 E70C-6M

Shielding gas: Ar-CO₂

Polarity: DCEP

Welding Positions:



Packaging data

φ mm	Spool		Drum	
	1.2	15kg	20kg	200kg
1.4	15kg	20kg	-	250kg
1.6	15kg	20kg	-	250kg
Volume mm	300W, 110H, 300L		530 φ, 820H	680 φ, 770H

Composition (all-weld metal mass%)

	Typical	Guaranty ^a
C	0.05	0.12
Si	0.74	0.90
Mn	1.58	1.75
P	0.01	0.03
S	0.01	0.03
Ni	0.02	0.50
Cr	0.03	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
1.2	150~350	150~300
1.4	200~450	200~400
1.6	250~500	250~450

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	450	400min.
TS (MPa)	550	483min.
El on 4d (%)	33	22min.
IV -40°C (J)	71	27min.

Approvals

ABS	4YSA, H5
LR	4YS, H5
DNV-GL	IVYMS, H5
BV	SA4YM, H5