

FCAW

MX-100

FAMILIARC™

Flux cored wire

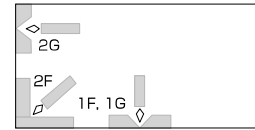
Features: ■ Suitable for butt and fillet welding

Classification: AWS A5.20 E70T-1C

Shielding gas: CO₂

Polarity: DCEP

Welding Positions:



Packaging data

| φ mm | Spool | Drum |
|------------------|------------------|--------------|
| 1.2 | 20kg | - |
| 1.4 | 15kg, 20kg | 250kg |
| 1.6 | 20kg | - |
| 2.0 | 20kg | - |
| Volume mm | 300W, 110H, 300L | 530 φ , 820H |

Composition (all-weld metal mass%)

| | Typical | Guaranty ^a |
|-----------|---------|-----------------------|
| C | 0.05 | 0.12 |
| Si | 0.68 | 0.90 |
| Mn | 1.48 | 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 | 0.35 |

Note: ^aSingle values are maximum.

Welding parameters (A)

| φ mm | 1F, 1G | 2F, 2G |
|------|---------|---------|
| 1.2 | 200~350 | 200~300 |
| 1.4 | 250~450 | 250~400 |
| 1.6 | 300~500 | 300~450 |
| 2.0 | 400~600 | 400~500 |

All-weld mechanical properties

| | Typical | Guaranty |
|---------------------|---------|----------|
| 0.2%YS (MPa) | 510 | 400min. |
| TS (MPa) | 580 | 490~655 |
| El on 4d (%) | 30 | 22min. |
| IV -18°C (J) | 50 | 27min. |

Approvals

| | |
|---------------|------------|
| ABS | 2YSA |
| LR | 2YS, H10 |
| DNV-GL | II YMS |
| BV | SA2YM |
| NK | KSW52G (C) |
| CR | 2YS |