

GMAW

# MG-60

**TRUSTARC™**

## Solid wire

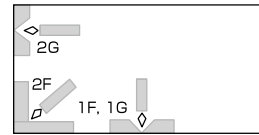
**Features:** ■ Suitable for flat, horizontal and horizontal fillet welding

**Classification:** -

**Shielding gas:** CO<sub>2</sub>

**Polarity:** DCEP

## Welding Positions:



## Packaging data

φ mm	Spool
0.9	20kg
1.2	20kg
1.4	20kg
1.6	20kg
<b>Volume mm</b>	280W, 110H, 270L

## Composition (wire mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.04	0.12
<b>Si</b>	0.82	0.60~1.00
<b>Mn</b>	1.95	1.40~2.10
<b>P</b>	0.013	0.025
<b>S</b>	0.010	0.025
<b>Mo</b>	0.35	0.10~0.45
<b>Cu</b>	0.25	0.50
<b>Ti</b>	0.20	0.02~0.30

Note: <sup>a</sup> Single values are maximum.

## Welding parameters (A)

φ mm	1F, 1G, 2F	2G
0.9	50~200	50~180
1.2	100~350	100~300
1.4	150~450	150~350
1.6	200~550	200~400

## All-weld mechanical properties

	Typical		Guaranty
<b>0.2%YS (MPa)</b>	590	570	500min.
<b>TS (MPa)</b>	670	660	552min.
<b>El on 4d (%)</b>	28	29	19min.
<b>IV -18°C (J)</b>	90	80	-5°C: 47min.
<b>PWHT (°Cxh)</b>	AW	620x5	AW

## Approvals

<b>ABS</b>	3YQ500
<b>DNV-GL</b>	III Y46MS, MG
<b>NK</b>	KSW3Y50G (C) H5