

FCAW

# MX-A55T

**TRUSTARC™**

## Flux cored wire

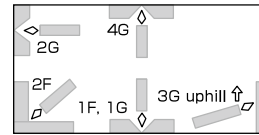
- Features:**
- Suitable with a short circuit arc
  - Excellent impact value down to -60°C

**Classification:** AWS A5.28 E80C-G

**Shielding gas:** Ar-20%CO<sub>2</sub>

**Polarity:** DCEP

### Welding Positions:



## Packaging data

φ mm	Spool
1.2	15kg
Volume mm	300W, 110H, 300L

## Composition (all-weld metal mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.05	0.15
<b>Si</b>	0.40	0.80
<b>Mn</b>	1.40	0.50~1.75
<b>P</b>	0.010	0.030
<b>S</b>	0.014	0.030
<b>Ni</b>	1.42	1.00~2.00
<b>Cr</b>	0.02	0.15
<b>Mo</b>	0.01	0.20
<b>V</b>	0.01	0.05
<b>Cu</b>	0.04	0.30

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

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
1.2	50~300	50~180

## All-weld mechanical properties

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	540	469min.
<b>TS (MPa)</b>	600	552~689
<b>EI on 4d (%)</b>	29	19min.
<b>IV -60°C (J)</b>	90	27min.

## Approvals

<b>LR</b>	5Y40S, H5
<b>DNV-GL</b>	VYMS (H5)
<b>BV</b>	SA3YM H5, UP