

GMAW

# SE-A50

**FAMILIARC™**

## Solid wire

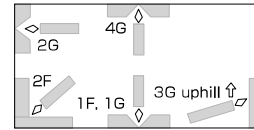
- Features:**
- Smooth wire feeding, Smooth arc start and stable arc with little spatter generation
  - The special surface treatment that eliminates the need for Cu coating

**Classification:** AWS A5.18 ER70S-G

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

**Polarity:** DCEP

### Welding Positions:



## Packaging data

φ mm	Spool		Drum			
	10kg	20kg	-	250kg	-	-
0.9	10kg	20kg	-	250kg	-	-
1.0	10kg	20kg	-	250kg	-	-
1.2	10kg	20kg	100kg	-	300kg	400kg
<b>Volume mm</b>	240W, 110H, 240L	300W, 110H, 300L	530 φ, 820H		680 φ, 770H	

## Composition (wire mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.05	0.02~0.15
<b>Si</b>	0.89	0.40~1.00
<b>Mn</b>	1.40	0.90~1.60
<b>P</b>	0.010	0.030
<b>S</b>	0.015	0.030
<b>Cu</b>	0.01	0.50
<b>Ni</b>	0.01	0.15
<b>Cr</b>	0.02	0.15
<b>Mo</b>	<0.01	0.15
<b>V</b>	<0.01	0.03

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

## Welding parameters (A)

φ mm	1F, 1G	3G uphill, 4G
0.9	50~220	50~150
1.0	50~250	50~160
1.2	80~300	50~180

## All-weld mechanical properties

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	460	400min.
<b>TS (MPa)</b>	559	490min.
<b>El on 4d (%)</b>	30	22min.
<b>IV -20°C (J)</b>	120	27min.

## Approvals

NK	KSW53G (M2)