MC-60

For 60kgf/mm^2 class high tensile strength steel

AWS	A5.18	ER80S-G
KS	D 7025	YGW21
JIS	Z3312	YGW21

Applications

Butt and fillet MAG welding of structures using 60kgf/mm^2 class high tensile strength steel such as civil construction equipments, steel frames, bridges and pressure vessels.

Characteristics

(1) shows excellent usability which is equal to the solid wire for mild steels and 50kgf/mm^2 high tensile steels.
(2) As the deposition rate is very high and the penetration is deep, high efficiency welding is obtained.
(3) The arc stability is good and spatter loss is low. So, welding job is easy.
(4) The deposition efficiency is high because of no slag formation, the welding time is saved.

Notes on usage

Preheating at 100~150℃ is required when a plate is thick and restraint is high.

Typical chemical composition of weld metal (%)

(Shield Gas : 100%CO_2)

C	Mn	Si	P	S	Mo
0.07	1.35	0.49	0.009	0.010	0.25

Typical mechanical properties of weld metal

(Shield Gas : 100%CO_2)

YP N/mm^2(kgf/mm^2)	TS N/mm^2(kgf/mm^2)	EL %	IV J (kgf-m)
			-30℃
590(60)	670(68)	26	90(9.2)

Size & recommended current range (DC +)

Dia. (mm)	1.2	1.6
Amp.	100-360	170-550