

MC-50B

For mild steel and 50kgf/mm² class high tensile strength steel

AWS A5.18 ER70S-G
KS D 7025 YGW15
JIS Z3312 YGW15

Applications

Butt and fillet MAG welding of structures such as automobiles, vehicles, electric appliances, ships, steel frames, bridges in all position.

Characteristics

- (1) MC-50B is solid wire designed for all position welding.
- (2) High speed welding of steel sheets can be performed easily by short-circuit welding.
- (3) Arc is stable and spatter loss is low.

Notes on Usage

- (1) Use welding grade with 75~85%Ar+15~25%CO₂.
- (2) Flow quantity of shielding gas should be 25ℓ/min. generally.
- (3) Use the wind screen against wind.
- (4) Keep the distance between tip and basemetal of 6~15mm for less than 250A, and 15~25mm for more than 250A of welding current.

Typical chemical composition of weld metal (%) (Shield Gas : 80%Ar+20%CO₂)

C	Mn	Si	P	S
0.08	0.98	0.48	0.014	0.012

Typical mechanical properties of weld metal (Shield Gas : 80%Ar+20%CO₂)

YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %	IV J (kgf-m)	S.R (PWHT)
			-20°C	
450(46)	540(55)	30.0	140(14)	As Welded

Size & recommended current range (DC +)

Dia. (mm)		0.9	1.0	1.2	1.4	1.6
Amp.	F&H-F	50~200	50~200	80~350	100~470	200~250
	V	50~140	50~140	50~160	100~180	-
	OH	50~120	50~120	50~140	-	-