

80%Ar - 20%CO₂

EN ISO 17632-A-T 46 4 M M 1 H5

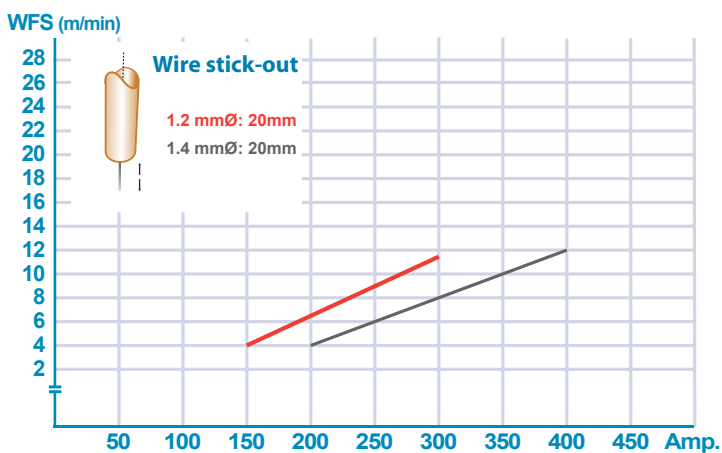
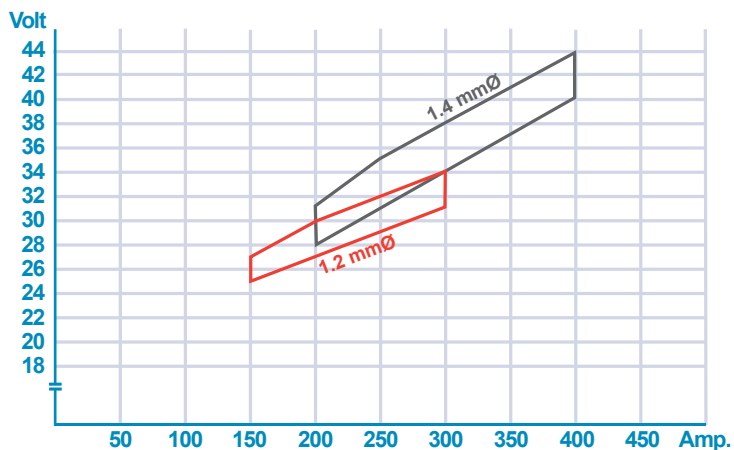
AWS A5.18 E70C-6M

Description and Application

FAMILIARC™ MX-A55S is a metal cored wire that produces low hydrogen weld-metal with good mechanical properties. The ability of FAMILIARC™ MX-A55S to be welded with negative polarity (=/-) greatly widens its application range, especially for high speed vertical down welding.

This wire is very well suited for constructional steel work, ship building, bridge construction, tank building, etc.

Recommended Parameter Range, for flat position*



* The above values and parameters are for all weld metal produced using 100%CO₂ shielding gas

Typical Chemical Analysis (wt. %)

Polarity	C	Si	Mn	P	S	Ni	Cr	Mo
DC+	0.08	0.52	1.43	0.008	0.009	-	-	-
DC-	0.08	0.50	1.39	0.009	0.009	-	-	-

Typical Mechanical Properties

Polarity	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-30°C	CV(J)-40°C
DC+	510	600	30	122	110
DC-	523	604	29	130	116
Guarantee	min.460	530~680	min.20	min.47	min.47

Welding Positions



Approvals

LR	DNV	BV	GL	ABS	R.M.R.S	Others
4Y42	IVY42	-	4Y40S	-	-	TÜV,DB