

# MC-50T

For mild steel and 50kgf/mm<sup>2</sup> class high tensile strength steel

AWS A5.18 ER70S-6  
KS D 7025 YGW12  
JIS Z3312 YGW12

## Applications

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

## Characteristics

- (1) MC-50T is a solid wire whose arc stability is good at low current ranges (short-circuiting arc range) and spatter loss is low.
- (2) It is suitable for all-position welding of steel sheets by CO<sub>2</sub> or Ar+CO<sub>2</sub> mixed gas shielding, for higher speed welding.
- (3) The arc stability is good in wide range of current.

## Notes on Usage

- (1) Flow rate of shielding gas (CO<sub>2</sub>) should be 20ℓ/min generally.
- (2) Flow rate of shielding gas should be 25~30ℓ/min under the condition of 2m/sec wind speed and use wind screen under the condition of over 2m/sec wind speed.
- (3) Keep the distance between tip and basemetal within 10~20mm at less than 300A Welding current and within 20~25mm at over 300A.

## Typical chemical composition of weld metal (%)

(Shield Gas : 100%CO<sub>2</sub>)

C	Mn	Si	P	S
0.09	1.8	0.50	0.015	0.012

## Typical mechanical properties of weld metal

PWHT	YP N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	TS N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	EL %	IV J (kgf-m)		Shield gas
				0°C	-20°C	
As welded	470(48)	550(56.1)	30	120(12.2)	100(10.2)	100%CO <sub>2</sub>
As welded	540(55.1)	610(62.2)	28	140(14.3)	120(12.2)	80%Ar+20%CO <sub>2</sub>

## Size & recommended current range (DC +)

Dia. (mm)		0.9	1.0	1.2	1.4	1.6
Amp.	F	50-200	50-200	80-350	100-470	200-550
	H	50-140	50-140	50-160	100-180	-
	OH	50-120	50-120	50-140	-	-

• Approval : ABS, BV, DNV, GL, KR, LR, NK, CWB