

# MC-50A

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

AWS	A5.18	ER70S-3
KS	D 7025	YGW16
JIS	Z3312	YGW16

## Applications

Butt and fillet welding of vehicles, buildings, ships, machinery etc.

## Characteristics

- (1) MC-50A is a 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%CO<sub>2</sub>.
- (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%CO<sub>2</sub>)

C	Mn	Si	P	S
0.08	0.98	0.48	0.015	0.012

## Typical mechanical properties of weld metal (Shield Gas : 80%Ar+20%CO<sub>2</sub>)

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)
			-20℃
450(46)	540(55)	30	145(15)

## Sizes Available and Recommended Currents (Amp.)

Dia. (mm)		0.9	1.0	1.2	1.4	1.6
Amp.	F	50-200	50-220	80-350	140-400	200-500
	V-up&OH	50-120	50-140	50-160	100-250	120-300