

Metal Cored Wire

MXC 760C

AWS A5.18M E49C-6C/AWS A5.18 E70C-6C
JIS Z 3313 T49J3T15-1CA
ISO 17632-A-T 46 3 M C1 1

Product Features:

- Composite wire for welding of mild and 490 N/mm² high tensile strength steel with CO₂ shielding gas.
- High welding performance, almost no spatter loss.
- Very few slag and easy removed, more higher deposition efficiency than similar strength level solid wires.
- Low hydrogen contained in weld metal to get good mechanical properties, crack resistance and impact toughness.

Applications:

- Suitable for welding of mild and 490 N/mm² high tensile strength steel structures on shipbuilding, buildings, bridges, machinery, heavy thickness steel castings and pressure vessels.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	P	S	Fe
0.05	0.65	1.50	0.013	0.008	Bal.

Typical mechanical properties of all-weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-30°C) J
510	578	29.0	78

Welding parameters

Diameter (mm)		1.2	1.6
Polarity		DC+	DC+
Ampere (A)	Flat, horizontal position	120~350	200~450
	Vertical upward position	120~250	180~280
	Vertical downward position	200~280	250~280
Shielding Gas		CO ₂	CO ₂

Note:

- Shielding gas flow rate : 20~25 L/min.
- Wire extension : 15~25mm(standard range)

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