

Description and Application

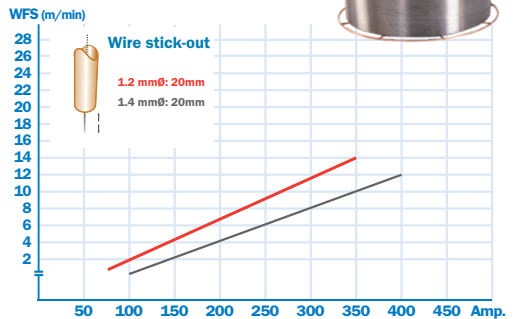
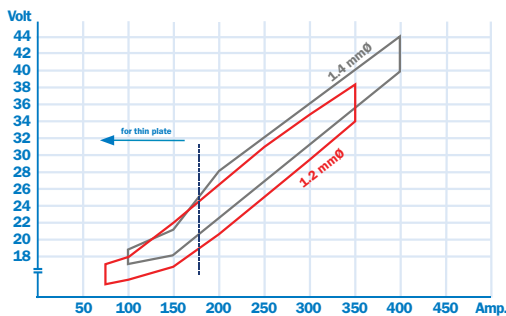
MX-A55T is a metal cored wire which has been developed for use with mixed gas and is specially designed to give good low temperature toughness, thus making it suitable for low temperature applications where conventional metal cored wires may not prove suitable.

This wire is applied for horizontal and downhand welding of thick sections and also for all positional root pass welding with short circuit arc transfer.

These properties result in a wire which is ideally suited to offshore fabrication and other applications where service temperatures down to -60°C are required.



Recommended Parameter Range, for flat position



Typical Chemical Analysis (wt. %)

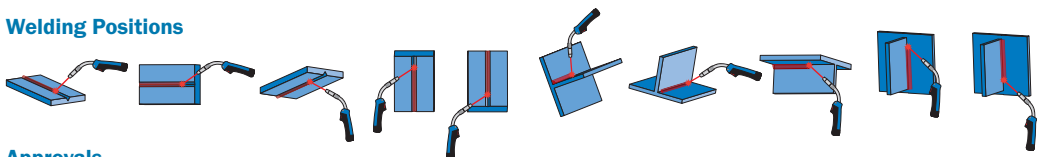
C	Si	Mn	P	S	Ni	Cr	Mo
0.06	0.35	1.41	0.011	0.017	1.48	-	-

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-40°C	CV(J)-60°C
Guaranty	517	598	31	100	97
	min.460	530~680	min.20	min.47	min.47

Example of Diffusible hydrogen content: 2.3 [ml/100g]

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
5Y40S H5	VYMS H5 NV2-4,4-4	SA3YM H5 MG	-	-	CE