

MXA-100

Metal type flux cored wire for mild steel and 490MPa high tensile strength steel

Classification: ASME / AWS A5.18 E70C-6M

EN 758 T 42 4 M M 3 H5

JIS Z3313 YFW-A50DM

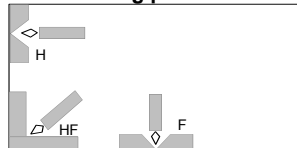
Features : •Suitable for butt and fillet welding

- Better arc stability and wider optimum current range for spray transfer arc with less spattering than solid wire

Shielding gas: Ar-CO₂ mixture

Polarity: DC-EP

Welding positions:



Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S
Example	0.05	0.63	1.58	0.017	0.011
Guaranty	≤0.18	≤0.90	≤1.75	≤0.03	≤0.03

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	El (%)	IV (J)
Example	450	550	33	-29°C: 89
Guaranty	≥400	≥483	≥22	-29°C ≥27

Recommended welding parameters

	1.2mm	1.4mm	1.6mm
F	150~350A	200~450A	250~500A
HF, H	150~300A	200~400A	250~450A

Approvals

LR	NV	BV	Others
3S,3YS(H5)	III YMS(H5)	SA3YM HHH	GL, TÜV, U(ic), DB

Packages

Dia. (mm)	Type	Weight (kg)
1.2	Spool	20
	Pack	350
1.4	Spool	20
	Pack	350
1.6	Spool	20
	Pack	350