

Description and Application

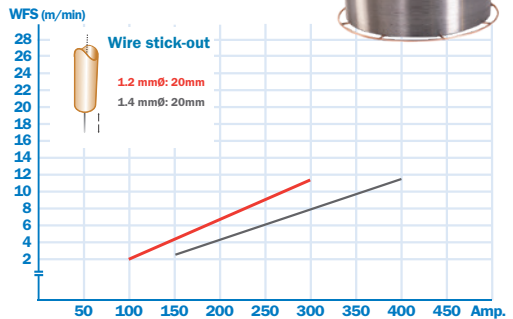
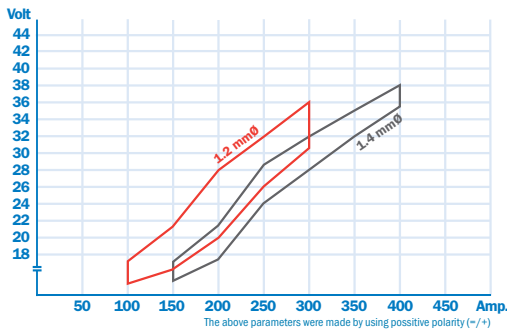
MX-A55S is a metal cored wire that produces low hydrogen weld-metal with good mechanical properties.

The ability of **MX-A55S** to be welded with negative polarity (=/-) greatly widens its application range, especially for high speed vertical down welding.

This wire is very well suited for constructional steel work, ship building, bridge construction, tank building, etc.



Recommended Parameter Range, for flat position



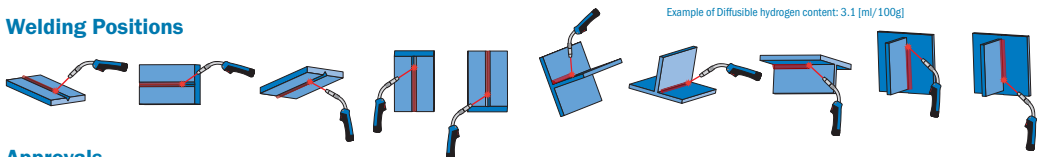
Typical Chemical Analysis (wt. %)

Polarity	C	Si	Mn	P	S	Ni	Cr	Mo
DC+	0.08	0.60	1.43	0.008	0.009	-	-	-
DC-	0.08	0.50	1.39	0.009	0.009	-	-	-

Typical Mechanical Properties

Polarity	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-30°C	CV(J)-40°C
DC+	510	600	30	122	110
DC-	523	604	29	130	116
Guaranty	min.460	530~680	min.20	min.47	min.47

Welding Positions



Example of Diffusible hydrogen content: 3.1 [ml/100g]

Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
4Y42S H5	IV Y42MS H5	-	-	-	TUV, DB