

## Description and Application

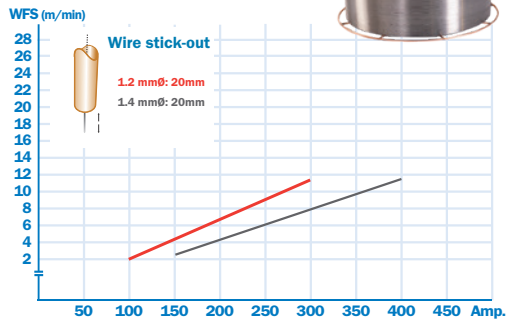
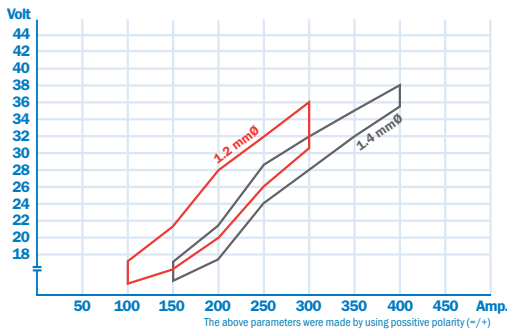
**MX-A55S** is a metal cored wire that produces low hydrogen weld-metal with good mechanical properties.

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



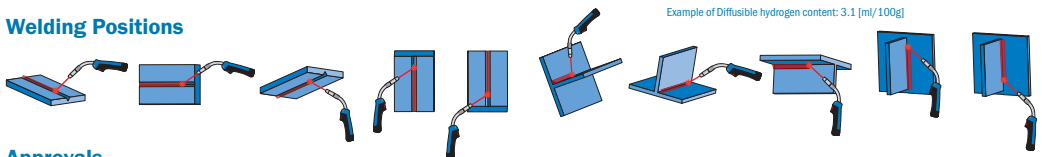
### Typical Chemical Analysis (wt. %)

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 <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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