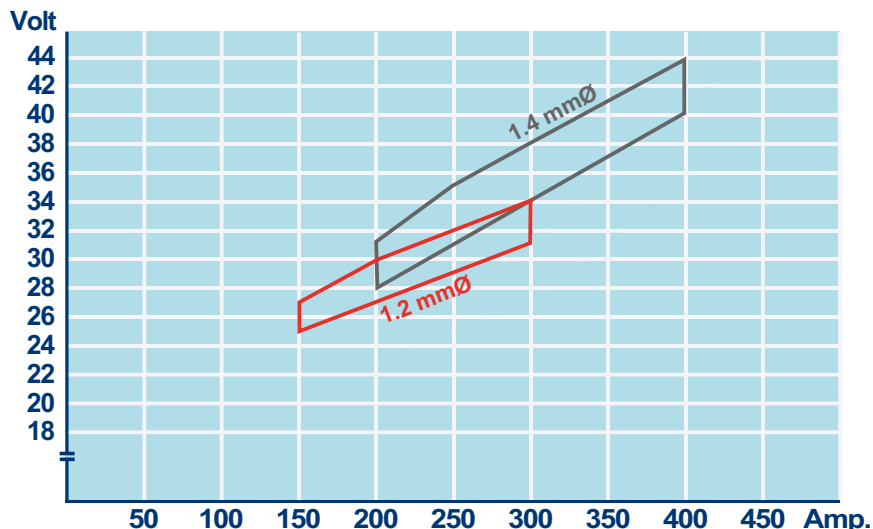


### Description and Application

MX-A55S is a metal cored wire. MX-A55S 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



### Chemical Analysis (wt.%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Shielding gas
MX-A55S (=/+)	0.08	0.52	1.43	0.008	0.009	-	-	-	80%Ar-20%CO <sub>2</sub>
MX-A55S (=/-)	0.08	0.50	1.39	0.009	0.009	-	-	-	80%Ar-20%CO <sub>2</sub>

### Mechanical Properties

	R <sub>e</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	CV (J) -30°C	CV (J) -40°C	Shielding gas
MX-A55S (=/+)	510	600	30	122	110	80%Ar-20%CO <sub>2</sub>
MX-A55S (=/-)	523	604	29	130	116	80%Ar-20%CO <sub>2</sub>

### Welding Positions

**MX-A55S**  
1.2, 1.4mm



### Approvals

	LR	DNV	BV	GL	ABS	R.M.R.S.	Others
MX-A55S	4Y42	IVY42	-	4Y40S	-	-	TÜV,DB