KOBELCO

Excellent porosity resistibility to inorganic zinc primer

FAMILIARC™

MX-A200

for 75-80%Ar-Bal.CO_2

AWS A5.20 E70T-1M
ABS,LR,DNV

FAMILIARC™

MX-200

for 100%CO_2

AWS A5.20 E70T-1C
ABS,LR,DNV,BV,GL

Outstanding Features

- Resist pits or worm tracks when welding inorganic zinc primer coated steel plate especially.
- Fast travel speeds with uniform leg length and excellent bead appearance in horizontal and flat welding.
- Good arc stability with low spatter.
- Higher deposition rates than regular flux-cored wire
- Non-baked wire surface covered with special lubricant creates smooth wire feedabilty and extended liner life.

Typical chemistry of weld metal and diffusible hydrogen content

Wire	C	Si	Mn	P	S	Diffusible hydrogen content (ml/100g)
MX-A200	0.06	0.62	1.60	0.010	0.009	3.9
MX-200	0.06	0.50	1.35	0.013	0.009	2.9

Gas chromatography method (AWS A4.3)

Typical mechanical property of weld metal

Wire	0.2%P.S (psi)	T.S (psi)	Elongation (%)	Impact value (ft-lbs)
				0 °F
MX-A200	78,300	88,500	29	49
MX-200	76,600	83,800	29	41

Test method: AWS A5.20

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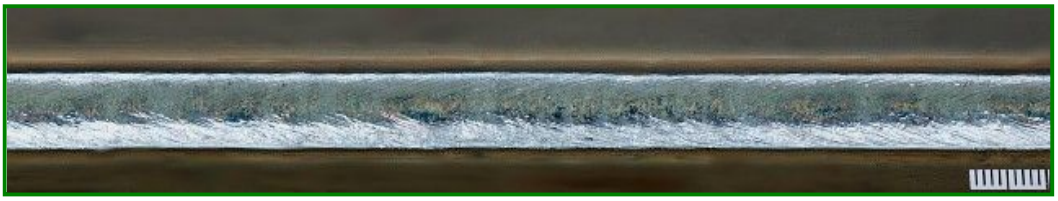
FAMILIARC™ **MX-A200** AWS A5.20 E70T-1M

FAMILIARC™ **MX-200** AWS A5.20 E70T-1C

Bead Appearance

MX-A200

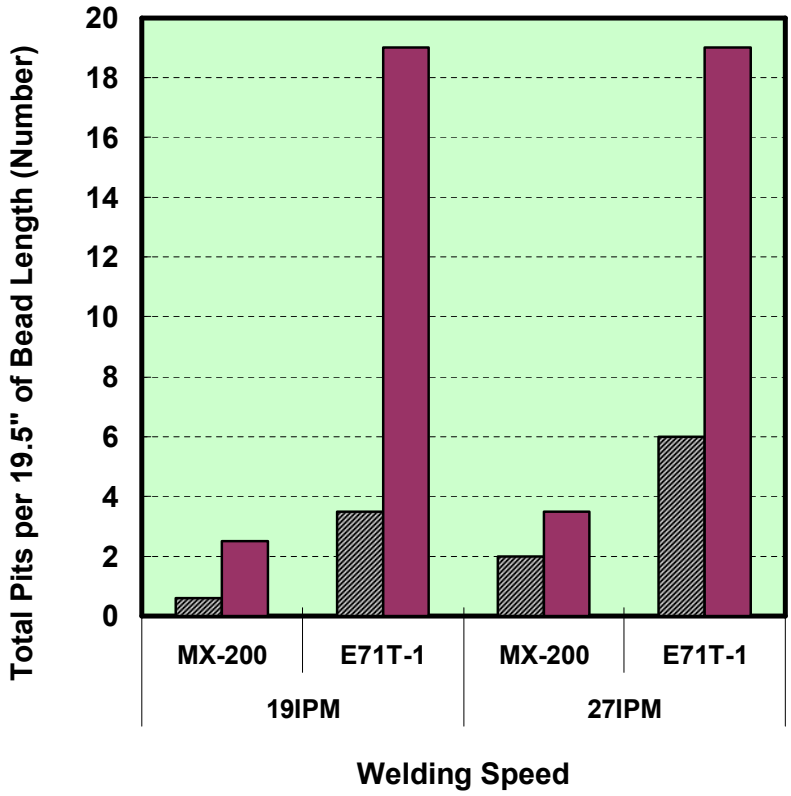
Horizontal fillet welding
0.052" 300A-15.7IPM
80%Ar-20%CO_2



MX-200

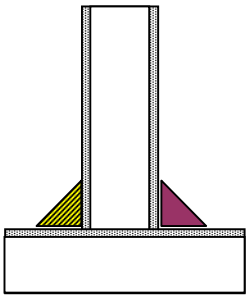
Horizontal fillet welding
0.045" 270A-19.5IPM
100%CO_2

PIT COMPARISON



WELDING CONDITIONS
Welding Current: 290A
Arc Voltage: 31V
Shielding Gas: 100%CO_2 (40CFH)
Plate Coating: Inorganic Primer
Coating Thickness: 30 μm

1st Bead
2nd Bead



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